



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

| S.No. | Check Parameter                       | Specification          | Observations             | Remarks                              |
|-------|---------------------------------------|------------------------|--------------------------|--------------------------------------|
| 1     | Work Order No.                        |                        | 9900                     | 40/45                                |
| 2     | Machined By                           |                        | V.T.L H/c Shop           | Dy No. 1202807                       |
| 3     | Pallet Die No.                        |                        | 10492 (6.0)H             | Res. 100                             |
| 4     | Die Category                          | Drg. No.               | Senior                   |                                      |
| 5     | Out Side Diameter                     | Drg. No.               | 510 H/c Step 002 492 H/c | Step length 17.5                     |
| 6     | Inside Diameter                       | Drg. No.               | 490.12 H/c               |                                      |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 H/c                  |                                      |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x8x3 mm / 12x8x3 mm    |                                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                       |                                      |
| 10    | Drilling Area Surface Smoothness      |                        | OK                       |                                      |
| 11    | Tapping Operator                      |                        | H/c Shop                 | Tapping No. of holes, 8<br>Back side |
| 12    | Tapping PCD                           |                        | 454 H/c                  |                                      |
| 13    | Tapping Hole Diameter                 |                        | drill check by only Ball |                                      |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                       |                                      |
| 15    | Tapping Hole Depth                    |                        | Drill Depth, 18.4 mm     | Tapping Depth, 16.8                  |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                      |                                      |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                       |                                      |

### Inspected By (Sign) & Date

Ravi 25/7/23

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 1 | As per programme no.           |        |    |
| 2 | Gun Drilling Work Completed On |        |    |
| 3 | Hole Finish In Gun Drilling    | Marked | OK |
| 4 | Defective Holes (If Any)       |        | No |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

|   |  |         |               |    |       |    |  |  |  |              |
|---|--|---------|---------------|----|-------|----|--|--|--|--------------|
| 1 | Counter Sinking Depth & Finish             | OK      |               |    |       |    |  |  |  | Ravi 25/7/23 |
| 2 | External Relief Dia                        | 6.5 H/c | Outside (2-2) |    | Inner |    |  |  |  |              |
| 3 | External Relief Depth                      | ✓       | 11 H/c        |    | 5 H/c |    |  |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |         |               |    |       |    |  |  |  | Ravi         |
| 5 | Material Sent For Hardening By (Name)      |         |               |    |       |    |  |  |  | Lark Furnace |
| 6 | Material Sent For Hardening On Date        |         |               | 25 | 7     | 23 |  |  |  |              |

### Inspected By (Sign) & Date

Ravi 25/7/23

Reviewed by (Engineer-CNC)

Manager-QA