



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|---------------------------------------|-------------------------------------|
| 1 | Work Order No. | | 11881 | 45/6 |
| 2 | Machined By | | V.T.L n/c Shop | Dy. Insp. L.S.O. 584 |
| 3 | Pallet Die No. | | 12297 (8.0) n/c | Revised |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 780 n/c, Step 00, 798 n/c | Tapper = 4° |
| 6 | Inside Diameter | Drg. No. | 660.12 n/c | Step length = 25.5 |
| 7 | Width of Pellet Die | Drg. No. | 324 n/c | Under cut = 9 n/c |
| 8 | Grooves as per Drawing | Drg. No. | 21.5 x 8 x 10 n/c / 21.5 x 8 x 10 n/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | n/c Shop | Tapping No. of Holes = 12 Both side |
| 12 | Tapping PCD | | 725 n/c | |
| 13 | Tapping Hole Diameter | | M20 - Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth = 31 n/c | Tapping Depth = 28.8 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Pavi 18/5/24

| | | | | |
|---|--------------------------------|--------|----|--|
| 1 | As per programme no. | | | 2 Slot 32.1 n/c width 8 n/c Depth Both side |
| 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 | | | | | | Counter = 6° Lead = 2° |
| 2 | External Relief Dia | 2.5 n/c | Outside 3-3) | Inner | | | | |
| 3 | External Relief Depth | | 23 n/c | 15 n/c | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Pavi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | |
| 6 | Material Sent For Hardening On Date | | 18 | 5 | 24 | | | |

Inspected By (Sign) & Date

Pavi 18/5/24

Sabin 18/5/24

Reviewed by (Engineer-CNC)

Manager-QA