

7554



# 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.                        |                        | 11932                                     | 33/40                            |
| 2     | Machined By                           |                        | V.T.L M/C SROP                            | Drg No - Lark Std                |
| 3     | Pallet Die No.                        |                        | 19347 (3.0mm)                             | 9109                             |
| 4     | Die Category                          | Drg. No.               | JUNIOR                                    |                                  |
| 5     | Out Side Diameter                     | Drg. No.               | 400mm, Step od - 395mm                    | Step length - 14.5mm             |
| 6     | Inside Diameter                       | Drg. No.               | 320.12mm                                  |                                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 142mm                                     |                                  |
| 8     | Grooves as per Drawing                | Drg. No.               | 15.5 X 7 X 2mm / 15.5 X 7 X 2mm           |                                  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok  | Tapping No. of Holes 8 Both Side |
| 10    | Drilling Area Surface Smoothness      |                        | ok  |                                  |
| 11    | Tapping Operator                      |                        | M/C SROP                                  |                                  |
| 12    | Tapping PCD                           |                        |   |                                  |
| 13    | Tapping Hole Diameter                 |                        | M16 check by M16 Bolt                     |                                  |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok  |                                  |
| 15    | Tapping Hole Depth                    |                        | Drill Depth - 21.2mm Tapping Depth - 19mm |                                  |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                       |                                  |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                                  |

Inspected By (Sign) & Date Ramanpreet Singh 24/5/24

|   |                                |        |    |  |
|---|--------------------------------|--------|----|--|
| 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 Counted - 60° Row - 20

|   |  |       |                  |       |    |  |  |
|---|--|-------|------------------|-------|----|--|--|
| 1 | Counter Sinking Depth & Finish             | ok    |                  |       |    |  |  |
| 2 | External Relief Dia                        | 3.3mm | outside (2-2)    | Inner |    |  |  |
| 3 | External Relief Depth                      |       | 13mm             | 7mm   |    |  |  |
| 4 | Inspection Done Before Hardening By (Name) |       | Ramanpreet Singh |       |    |  |  |
| 5 | Material Sent For Hardening By (Name)      |       | Lark Furnace     |       |    |  |  |
| 6 | Material Sent For Hardening On Date        |       | 24               | 5     | 24 |  |  |

Inspected By (Sign) & Date Ramanpreet Singh 24/5/24

Sats 24/5/24

Reviewed by (Engineer-CNC)

Manager-QA