



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. | | 12107 | 50/55 |
| 2 | Machined By | | V.T.L. H/C Shop | 1 Day Max L.S. 0.15 |
| 3 | Pallet Die No. | | 12431 (3.5)mm | Reason 14951 |
| 4 | Die Category | Drg. No. | Extra wide | |
| 5 | Out Side Diameter | Drg. No. | 630 H/C | Step OD = 601.5mm |
| 6 | Inside Diameter | Drg. No. | 520.12 H/C | Tappers 2° |
| 7 | Width of Pellet Die | Drg. No. | 222 H/C | Step length 215 |
| 8 | Grooves as per Drawing | Drg. No. | 13x8x5 H/C / 13x8x5 H/C | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | H/C Shop | |
| 12 | Tapping PCD | | 565mm | Tapping Holes of Holes, 10 Both Side |
| 13 | Tapping Hole Diameter | | H20 = Check by H20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth = 20.4mm | Tapping Depth = 18.5 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 25/6/24

| | | | |
|---|--------------------------------|--------|----|
| 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

| | | | | | | | |
|---|--|-------|---------------|---|-------|--|--------------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | Count = 6 |
| 2 | External Relief Dia | 4.0mm | outside (3-3) | | inner | | Now = 35 |
| 3 | External Relief Depth | | 12mm | | 5mm | | |
| 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 | 6 | 24 | | |

Inspected By (Sign) & Date

Ravi 25/6/24

Satya 25/6/24

Reviewed by (Engineer-CNC)

Manager-QA