



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. | | 12237 | 30/40/70 ✓ |
| 2 | Machined By | | V.T.L M/C SHOP | Drg No - LSD 648 |
| 3 | Pallet Die No. | | 10440 (6.0mm) | CRV04 ✓ |
| 4 | Die Category | Drg. No. | MJEW | |
| 5 | Out Side Diameter | Drg. No. | 712mm Step od - 777mm/776mm | Step length - 42mm / 245 |
| 6 | Inside Diameter | Drg. No. | ✓ 572.12mm ✓ | Under Cwt - 32.5mm / 1000 |
| 7 | Width of Pellet Die | Drg. No. | 270mm | ✓ |
| 8 | Grooves as per Drawing | Drg. No. | 106 X 8 X 12 / 88 X 8 X 12 mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK ✓ | [Tapping No. of Holes 6] |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/C SHOP | |
| 12 | Tapping PCD | | 660mm | |
| 13 | Tapping Hole Diameter | | 3/4 check by 3/4 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | 1 Side Tapping & 2nd side 1 slot | |
| 15 | Tapping Hole Depth | | Drill Depth - 35.5mm Tapping Depth - 33.5mm | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ramanpreet Singh 02/07/24

1 Slot 39mm

| | | | | |
|---|--------------------------------|--------|----|------------|
| 1 | As per programme no. | | — | Width 26mm |
| 2 | Gun Drilling Work Completed On | | — | Deep |
| 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

Counter - 60° ✓

| | | | | | | | |
|---|--|--------------|------------------|-------|----------|--|---------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | Row - 7 |
| 2 | External Relief Dia | 6.5mm, 7.0mm | 6.5mm | 7.0mm | | | |
| 3 | External Relief Depth | | 40mm | 30mm | All Rows | | |
| 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 | | 02 | 07 | 24 | | |

Inspected By (Sign) & Date

Ramanpreet Singh 02/07/24

Reviewed by (Engineer-CNC)

Manager-QA