



# 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.                        |                        | 12243                         | 26/36/66                            |
| 2     | Machined By                           |                        | V.T.L M/C SHOP                | Drg No- LSP 609                     |
| 3     | Pallet Die No.                        |                        | 12796 (6.0mm)                 | (REV 01)                            |
| 4     | Die Category                          | Drg. No.               | M. Jumbo                      | 820VC-4X300                         |
| 5     | Out Side Diameter                     | Drg. No.               | 680.7mm                       | Step OD- 693mm                      |
| 6     | Inside Diameter                       | Drg. No.               | 548.12mm                      | Step length- 31mm                   |
| 7     | Width of Pellet Die                   | Drg. No.               | 195mm                         | Taper- 8°                           |
| 8     | Grooves as per Drawing                | Drg. No.               | 32 X 7 X 8 mm / 32 X 7 X 8 mm | Under cut- 2.5mm                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                            | 4 X 8 mm                            |
| 10    | Drilling Area Surface Smoothness      |                        | OK                            | Tapping No. of Holes 4<br>Both side |
| 11    | Tapping Operator                      |                        | M/C SHOP                      |                                     |
| 12    | Tapping PCD                           |                        | 619mm                         |                                     |
| 13    | Tapping Hole Diameter                 |                        | M16 check by M16 Bolt         | Face Step<br>2mm Deep               |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                            | Both side                           |
| 15    | Tapping Hole Depth                    |                        | Drill Depth - 35mm            | Tapping Depth - 33mm                |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                           |                                     |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                            |                                     |

### Inspected By (Sign) & Date

Ramanjeet Singh 06/07/14

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

Counter - 30°

|   |  |              |                 |       |          |  |        |
|---|--|--------------|-----------------|-------|----------|--|--------|
| 1 | Counter Sinking Depth & Finish             | OK           |                 |       |          |  | Row-12 |
| 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) |              | Ramanjeet Singh |       |          |  |        |
| 5 | Material Sent For Hardening By (Name)      |              | Lark Furnace    |       |          |  |        |
| 6 | Material Sent For Hardening On Date        |              | 06              | 07    | 24       |  |        |

### Inspected By (Sign) & Date

Ramanjeet Singh 06/07/14

Sasouli  
06/07/14

Reviewed by (Engineer-CNC)

Manager-QA