



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. | | 12358 | 45/50 |
| 2 | Machined By | | V.T.L Mic Shop | Part No - LSD 406 |
| 3 | Pallet Die No. | | 12628 (3.2mm) | (REV 00) |
| 4 | Die Category | Drg. No. | SSEW | |
| 5 | Out Side Diameter | Drg. No. | 620mm | Step Length - 18mm |
| 6 | Inside Diameter | Drg. No. | 520.12mm | Taper - 12° |
| 7 | Width of Pellet Die | Drg. No. | 222mm | Undercut - 1.2mm |
| 8 | Grooves as per Drawing | Drg. No. | 13 X 8 X 5mm / 13 X 8 X 5mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | [Tapping No. of Holes 12 Both Side] |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | Mic Shop | |
| 12 | Tapping PCD | | 565mm | |
| 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 - 20.3mm Tapping Depth - 18.5mm | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ramanpreet Singh 10/07/24

| | | | |
|---|--------------------------------|--------|-----------------|
| 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 2 Hole close |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60°

| | | | | | | | | | | |
|---|--|-------|------------------|-------|----|--|--|--|--|----------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | | Row - 37 |
| 2 | External Relief Dia | 3.8mm | outside (3.2) | Inner | | | | | | |
| 3 | External Relief Depth | | 12mm | 5mm | | | | | | |
| 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 | | 10 | 07 | 24 | | | | | |

Inspected By (Sign) & Date

Ramanpreet Singh 10/07/24

Sats
10/7/24

Reviewed by (Engineer-CNC)

Manager-QA