



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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. | | 12216 | 34/45/55 |
| 2 | Machined By | | V.T.L M/C Shop | Drg No - LSP 585 |
| 3 | Pallet Die No. | | 12351 (3.5mm) | (Rev00) |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 27.70mm, Step OD - 8.02mm | Step Length - 30mm |
| 6 | Inside Diameter | Drg. No. | 66.12mm | Tapper 10° |
| 7 | Width of Pellet Die | Drg. No. | 290mm | Under cut 216mm |
| 8 | Grooves as per Drawing | Drg. No. | 27.70mm 7.5mm 27.70mm 7.5mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | [Tapping No. of] |
| 10 | Drilling Area Surface Smoothness | | OK | Holes 12 |
| 11 | Tapping Operator | | M/C Shop | Both Side |
| 12 | Tapping PCD | | 724mm | |
| 13 | Tapping Hole Diameter | | MRR check by MRR Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth - 29.4mm, Tapping Depth - 27.5mm | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ramanpreet Singh 20/07/24

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

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

Counter - 60°

| | | | | | | | | |
|---|--|--------------|------------------|-------|----|--|--|----------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | Row - 43 |
| 2 | External Relief Dia | 4.0mm, 4.5mm | 4.0mm | 4.5mm | | | | |
| 3 | External Relief Depth | | 2.0mm | 1.0mm | | | | |
| 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 | | 20 | 07 | 24 | | | |

Inspected By (Sign) & Date

Ramanpreet Singh 20/07/24

Signature
22/7/24

Reviewed by (Engineer-CNC)

Manager-QA