



Lark Engineering Company (India) Pvt. Ltd.

L.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. | | | |
| 2 | Machined By | | ZNV | 40/40 |
| 3 | Pallet Die No. | | V.T.L M/c Shop | Dwg No - 11C 15047 |
| 4 | Die Category | Drg. No. | 11833 (40mm) | (Rev00) |
| 5 | Out Side Diameter | Drg. No. | Senior | |
| 6 | Inside Diameter | Drg. No. | 500mm | Step od - 498.88mm |
| 7 | Width of Pellet Die | Drg. No. | 420.12mm | Step Length - 18mm |
| 8 | Grooves as per Drawing | Drg. No. | 158mm | Taper - 1° |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 12X8X3mm / 12X8X3mm | |
| 10 | Drilling Area Surface Smoothness | Drg. No. | ok | Tapping No. of Holes 8 |
| 11 | Tapping Operator | | M/c Shop | |
| 12 | Tapping PCD | | 454mm | |
| 13 | Tapping Hole Diameter | | M to check by M to Bolt | Both Side |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth - 18.4mm | Tapping Depth - 16.5mm |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ramanpreet Singh 17/06/24

| | | | |
|---|--------------------------------|--------|-----------------|
| 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 1 Hole close |

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

| | | | | | | | | | |
|---|--|-------|------------------|-------|----|--|--|--|--------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | Row-20 |
| 2 | External Relief Dia | 4.3mm | outside (2-2) | Inner | | | | | |
| 3 | External Relief Depth | | 4mm | 0 | | | | | |
| 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 | | 17 | 06 | 24 | | | | |

Inspected By (Sign) & Date

Ramanpreet Singh 17/06/24

Reviewed by (Engineer-CNC)

Manager-QA