



# 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.                        |                        | 19534                                       | 40/50                                |
| 2     | Machined By                           |                        | V.T.L M/c Shop                              | Drg No - Last Std                    |
| 3     | Pallet Die No.                        |                        | 19811 (3.0mm)                               | 6355                                 |
| 4     | Die Category                          | Drg. No.               | SEFW  |                                      |
| 5     | Out Side Diameter                     | Drg. No.               | 620mm                                       | Step length - 17.5mm                 |
| 6     | Inside Diameter                       | Drg. No.               | 520-12mm                                    |                                      |
| 7     | Width of Pellet Die                   | Drg. No.               | 222mm                                       |                                      |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5mm / 13x8x5mm                         |                                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK  | [ Tapping No. of Holes R Both Side ] |
| 10    | Drilling Area Surface Smoothness      |                        | OK  |                                      |
| 11    | Tapping Operator                      |                        | M/c 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 - 20.4mm Tapping Depth - 18.5mm |                                      |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes   |                                      |
| 17    | Visual Inspection Before Gun Drilling |                        | OK  |                                      |

### Inspected By (Sign) & Date

Ramanpreet Singh 31/07/14

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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-60°

|   |  |       |                  |       |    |  |  |  |  |        |
|---|--|-------|------------------|-------|----|--|--|--|--|--------|
| 1 | Counter Sinking Depth & Finish             | OK    |                  |       |    |  |  |  |  | Row-38 |
| 2 | External Relief Dia                        | 5.3mm | Outside (3-3)    | Inner |    |  |  |  |  |        |
| 3 | External Relief Depth                      | ✓     | 16mm             | 10mm  |    |  |  |  |  |        |
| 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        |       | 31               | 07    | 24 |  |  |  |  |        |

### Inspected By (Sign) & Date

Ramanpreet Singh 31/07/14

Jato  
31/07/14

Reviewed by (Engineer-CNC)

Manager-QA