

7924



# 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.                        |                        | 18890                                       | 49/50                             |
| 2     | Machined By                           |                        | V.T.L M/C SHOP                              | Drg No - Lark Std                 |
| 3     | Pallet Die No.                        |                        | 11667 (4.0mm)                               | 8752                              |
| 4     | Die Category                          | Drg. No.               | SSSTD                                       |                                   |
| 5     | Out Side Diameter                     | Drg. No.               | 620.44 Step OD - 612.44                     | Step Length - 19.5mm              |
| 6     | Inside Diameter                       | Drg. No.               | 520.12.44                                   |                                   |
| 7     | Width of Pellet Die                   | Drg. No.               | 186mm                                       |                                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 13X8X5mm / 13X8X5mm                         |                                   |
| 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                      |                        | 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 01/08/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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  
Row - 25

|   |  |       |                  |     |    |  |  |
|---|--|-------|------------------|-----|----|--|--|
| 1 | Counter Sinking Depth & Finish             | OK    |                  |     |    |  |  |
| 2 | External Relief Dia                        | 4.5mm | outside (3-3)    | 2mm |    |  |  |
| 3 | External Relief Depth                      |       | 18mm             | 8mm |    |  |  |
| 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        |       | 01               | 08  | 24 |  |  |

**Inspected By (Sign) & Date**

Ramanpreet Singh 01/08/24

Satya 1/8/24

Reviewed by (Engineer-CNC)

Manager-QA