



# 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.                        |                        | 12663   | 32/50                                 |
| 2     | Machined By                           |                        | VTL Mic Shop                                  | Drg No - Lark Std                     |
| 3     | Pallet Die No.                        |                        | 7466 (3.0mm)                                  | 8759                                  |
| 4     | Die Category                          | Drg. No.               | SSSTD   |                                       |
| 5     | Out Side Diameter                     | Drg. No.               | 620 mm  | Step OD - 612mm                       |
| 6     | Inside Diameter                       | Drg. No.               | 520.12mm                                      | Step length - 19.5mm                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 186 mm  |                                       |
| 8     | Grooves as per Drawing                | Drg. No.               | 13 X 8 X 5 mm / 13 X 8 X 5 mm                 |                                       |
| 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                           |                        | 565 mm  |                                       |
| 13    | Tapping Hole Diameter                 |                        | M 20 check by M 20 Bolt                       |                                       |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK  |                                       |
| 15    | Tapping Hole Depth                    |                        | Drill Depth - 20.4 mm Tapping Depth - 18.5 mm |                                       |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes   |                                       |
| 17    | Visual Inspection Before Gun Drilling |                        | OK  |                                       |

### Inspected By (Sign) & Date

Ramanpreet Singh 13/08/24

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

|   |  |        |                  |       |    |  |  |  |        |
|---|--|--------|------------------|-------|----|--|--|--|--------|
| 1 | Counter Sinking Depth & Finish             | OK     |                  |       |    |  |  |  | Row-30 |
| 2 | External Relief Dia                        | 3.5 mm | outside (3-3)    | Inner |    |  |  |  |        |
| 3 | External Relief Depth                      |        | 21 mm            | 18 mm |    |  |  |  |        |
| 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        |        | 13               | 08    | 24 |  |  |  |        |

### Inspected By (Sign) & Date

Ramanpreet Singh 13/08/24

Sat 13/8/24

Reviewed by (Engineer-CNC)

Manager-QA