



# 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.                        |                        | 19682 ✓                                     | 35 / 40 ✓                            |
| 2     | Machined By                           |                        | V.T.L M/c Shop                              | Drg No - Lark Std                    |
| 3     | Pallet Die No.                        |                        | 12354 (3.2mm)                               | P195                                 |
| 4     | Die Category                          | Drg. No.               | Senior ✓                                    |                                      |
| 5     | Out Side Diameter                     | Drg. No.               | 500mm                                       | Step length - 17.4 ✓                 |
| 6     | Inside Diameter                       | Drg. No.               | Step od - 491mm                             |                                      |
| 7     | Width of Pellet Die                   | Drg. No.               | 470.12mm ✓                                  |                                      |
| 8     | Grooves as per Drawing                | Drg. No.               | 158mm ✓                                     |                                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 12x8x3mm / 12x8x3mm                         |                                      |
| 10    | Drilling Area Surface Smoothness      |                        | ok  | [ Tapping No. of Holes 8 Both Side ] |
| 11    | Tapping Operator                      |                        | ok  |                                      |
| 12    | Tapping PCD                           |                        | M/c Shop                                    |                                      |
| 13    | Tapping Hole Diameter                 |                        | 454mm ✓                                     |                                      |
| 14    | Tapping On Second Side                | Half pitch of 1st side | M20 Check by M20 Bolt                       |                                      |
| 15    | Tapping Hole Depth                    |                        | ok  |                                      |
| 16    | Perpendicularity of Tapped Hole       |                        | Drill Depth - 18.4mm Tapping Depth - 16.5 ✓ |                                      |
| 17    | Visual Inspection Before Gun Drilling |                        | Yes   |                                      |
|       |                                       |                        | ok  |                                      |

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 - 650 Row - P3

|   |  |         |                  |       |    |  |  |  |
|---|--|---------|------------------|-------|----|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok      |                  |       |    |  |  |  |
| 2 | External Relief Dia                        | 3.5mm ✓ | outside (P-P)    | Inner |    |  |  |  |
| 3 | External Relief Depth                      |         | 11mm ✓           | 5mm ✓ |    |  |  |  |
| 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        |         | 24               | 08    | 24 |  |  |  |

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

Reviewed by (Engineer-CNC)

Manager-QA