



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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. | | 19634 ✓ | 28/50 ✓ |
| 2 | Machined By | | V.T.L M/c Shop | Drg No- LSP 344 |
| 3 | Pallet Die No. | | 11998 (P.8mm) | (Rev 00) |
| 4 | Die Category | Drg. No. | MJEW | |
| 5 | Out Side Diameter | Drg. No. | 700mm Set of 00. 692mm Side length 19.5 | |
| 6 | Inside Diameter | Drg. No. | 600.12mm ✓ | |
| 7 | Width of Pellet Die | Drg. No. | 265mm ✓ | |
| 8 | Grooves as per Drawing | Drg. No. | 15X8X7mm / 15X8X7mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | Tapping No. of Holes 18 Both Side ✓ |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/c Shop | |
| 12 | Tapping PCD | | 640mm ✓ | |
| 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 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 - 60 Row - 49 ✓

| | | | | | | | |
|---|--|-------|------------------|-------|----|--|--|
| 1 | Counter Sinking Depth & Finish | OK | | | | | |
| 2 | External Relief Dia | 3.2mm | outside 3.2 | Inner | | | |
| 3 | External Relief Depth | | 25mm | 22mm | | | |
| 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 | | P4 | 08 | P4 | | |

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

Satsa 24/08/24

Reviewed by (Engineer-CNC)

Manager-QA