



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. | | 12657 ✓ | 45/50 |
| 2 | Machined By | | V.T.L M/c Shop | Des No- LSD 976 |
| 3 | Pallet Die No. | | 19313 (80mm) ✓ | (Revol) |
| 4 | Die Category | Drg. No. | Semiol | |
| 5 | Out Side Diameter | Drg. No. | 5 diam, Stepon, 492 | Step Length- 13.5mm |
| 6 | Inside Diameter | Drg. No. | ⓐ 490.12 mm | |
| 7 | Width of Pellet Die | Drg. No. | 152mm ✓ | |
| 8 | Grooves as per Drawing | Drg. No. | 11 X 5 X 3mm / 11 X 5 X 3mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok ✓ | [Tapping No. of] |
| 10 | Drilling Area Surface Smoothness | | ok | Holes 3 |
| 11 | Tapping Operator | | M/c Shop | [Both Side] |
| 12 | Tapping PCD | | 456mm ✓ | |
| 13 | Tapping Hole Diameter | | 3/4" check by 3/4" Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth- 18.44 Tapping Depth- 14.5 mm | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ramanjeet Singh 26/08/24

| | | | |
|---|--------------------------------|--------|----|
| 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- 1P |
| 2 | External Relief Dia | 8.5mm ✓ | outside (P-2) | Inner | | | | | |
| 3 | External Relief Depth | | 13mm | 5mm ✓ | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ramanjeet Singh | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | | |
| 6 | Material Sent For Hardening On Date | | 26 | 08 | 24 | | | | |

Inspected By (Sign) & Date

Ramanjeet Singh 26/08/24

29/8/24

Reviewed by (Engineer-CNC)

Manager-QA