



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter                       | Specification          | Observations                                | Remarks            |
|-------|---------------------------------------|------------------------|---|--------------------|
| 1     | Work Order No.                        |                        | 19799                                       | 40/48/55           |
| 2     | Machined By                           |                        | V.T.L M/c Shop                              | Drig No - LSD 666  |
| 3     | Pallet Die No.                        |                        | 19211 (6.0mm)                               | (REV00)            |
| 4     | Die Category                          | Drg. No.               | M. Jumbo                                    |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 710mm                                       | Step Length - 20mm |
| 6     | Inside Diameter                       | Drg. No.               | 600/12mm                                    | Tapped - 1°        |
| 7     | Width of Pellet Die                   | Drg. No.               | 222mm                                       |                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x10x7.5mm / 12x10x7.5mm                   |                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK  | [Tapping No. of    |
| 10    | Drilling Area Surface Smoothness      |                        | OK  | Holes 12           |
| 11    | Tapping Operator                      |                        | M/c Shop                                    | [Both Side]        |
| 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 09/09/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 - 22 |
| 2 | External Relief Dia                        | 6.5mm, 7.0mm | 6.5mm            | 7.0mm | ADD ROWS |  |  |          |
| 3 | External Relief Depth                      |              | 15mm             | 7mm   |          |  |  |          |
| 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        |              | 09               | 09    | 24       |  |  |          |

### Inspected By (Sign) & Date

Ramanpreet Singh 09/09/24

*Signature*  
9/9/24

Reviewed by (Engineer-CNC)

Manager-QA