# 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. | | 12924 | 22140 |
| 2 | Machined By | | V.T.L M/c Shop | Drg. No. 12.0.31 |
| 3 | Pallet Die No. | | 12460 (2.5) HM | Rev. 01 |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 500 MM, Step OD = 499 MM | Tapper = 12° |
| 6 | Inside Diameter | Drg. No. | 420.12 MM | Step length = 17 MM |
| 7 | Width of Pellet Die | Drg. No. | 158 MM | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 MM / 12x8x3 MM | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | M/c Shop | Tapping No. of Holes = 8 |
| 12 | Tapping PCD | | 454 MM | Both Side |
| 13 | Tapping Hole Diameter | | 03/4" = Check by 3/4" Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 18.4 MM | Tapping Depth = 16.5 |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | **Inspected By (Sign) & Date** | | Ravi 21/9/24 | |
| 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 — 3 Hole Colused | |

**Note :** Mark the defective holes/Missed holes with the help of Permanent Marker

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Counter = 60° Row = 22 |
| 2 | External Relief Dia | 2.8 MM | Outside (2-2) | | Inner | | | |
| 3 | External Relief Depth | | 18 MM | | 12 MM | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | |
| 6 | Material Sent For Hardening On Date | | 21 | 9 | 24 | | | |
| | **Inspected By (Sign) & Date** | | Ravi 21/9/24 | | | | | |

21/9/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner