



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. | | 12887 | 50/50 |
| 2 | Machined By | | V.T.L M/C Shop | Dry No L.S.D. 18 |
| 3 | Pallet Die No. | | 13171 | Rev: 02 |
| 4 | Die Category | Drg. No. | Saw | |
| 5 | Out Side Diameter | Drg. No. | 520mm | Step OD. 491mm |
| 6 | Inside Diameter | Drg. No. | 420mm | Step length 17.5mm |
| 7 | Width of Pellet Die | Drg. No. | 182mm | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3mm / 12x8x3 | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/C Shop | Tapping No |
| 12 | Tapping PCD | | 454mm | of Holes. 8 |
| 13 | Tapping Hole Diameter | | M.20 check by M.20 Bolt | Both Side |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth 18.4mm | Tapping Depth. 16.5mm |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 24/9/24

| | | | |
|---|--------------------------------|--------|----|
| 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 |

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

Counter - 60

| | | | | | | | | | | |
|---|--|-------|-----------|--|--------------|--|--|--|--|---------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | | |
| 2 | External Relief Dia | 5.3mm | outside | | | | | | | Row: 20 |
| 3 | External Relief Depth | | (2-2) 1mm | | Inner | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Nil | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Ravi | | | | | |
| 6 | Material Sent For Hardening On Date | | | | Lark furnace | | | | | |

Inspected By (Sign) & Date

Ravi. 24/9/24

[Signature]
24/9/24

Reviewed by (Engineer-CNC)

Manager-QA