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# 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. | | 13157 | 66/66 |
| 2 | Machined By | | V.T.L. M/c Shop | Dy Nos 1 & 2 = 936 |
| 3 | Pallet Die No. | | 13942 (3.5) MM | Roo+01 |
| 4 | Die Category | Drg. No. | S. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 1032 MM, Step OD = 1033 MM | Tapper = 3° |
| 6 | Inside Diameter | Drg. No. | 900.14 MM | Step length = 37 |
| 7 | Width of Pellet Die | Drg. No. | 374.9 MM | Under cut = 0.5 MM |
| 8 | Grooves as per Drawing | Drg. No. | ~~29.5 x 8 x 13 MM~~ 29.5 x 8 x 13 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 = 15 Both Side |
| 12 | Tapping PCD | | 970 MM | |
| 13 | Tapping Hole Diameter | | M24 = Check by M24 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | Ok | |
| 15 | Tapping Hole Depth | | Drill Depth = 38.3 MM Tapping Depth = 35.4 MM | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | Ok | |
| | **Inspected By (Sign) & Date** | | Ravi 10/12/24 | |
| 1 | As per programme no. | | — | 2 Slot 32.1 MM width 7.5 MM Deep, Both Side |
| 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 | | | | | | Roo+59 |
| 2 | External Relief Dia | 4.0 MM | OD Side (4-4) | | Inner | | | |
| 3 | External Relief Depth | | 13 MM | | 6 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 | | 10 | 12 | 24 | | | |
| | **Inspected By (Sign) & Date** | | Ravi 10/12/24 | | | | | |

Satish 10/12/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner