# 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. | | 13576 | 40/60/66 |
| 2 | Machined By | | V.T.L. M/c Shop | Drg No. LS.D = 6.9 |
| 3 | Pallet Die No. | | 13929 (6.0) MM | Rev = 03 |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 680.7 MM, Step OD = 692.8 MM | Tapper, 3° |
| 6 | Inside Diameter | Drg. No. | 546.12 MM (Bor = 548.2 MM) | Step length, 31 MM |
| 7 | Width of Pellet Die | Drg. No. | 195 MM | Under cut = 2.5 MM |
| 8 | Grooves as per Drawing | Drg. No. | 32 x 7 x 9.2 MM / 32 x 7 x 9.2 MM | (4 x 8) MM |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | [Face Side Step |
| 10 | Drilling Area Surface Smoothness | | ok | 2 MM Deep |
| 11 | Tapping Operator | | M/c Shop | Both Side] |
| 12 | Tapping PCD | | 619 MM | [Tapping No. |
| 13 | Tapping Hole Diameter | | M16 = Check by M16 Bolt | of Holes. 2 |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | Both Side] |
| 15 | Tapping Hole Depth | | Drill Depth. 33.4 MM Tapping Depth = 31.6 MM | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | **Inspected By (Sign) & Date** | | Ravi 20/12/24 | |
| 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

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Counter, 30° Row = 12 |
| 2 | External Relief Dia | 8.5 MM / 7.0 MM | 6.5 MM All Rows = | 28 MM | | | | |
| 3 | External Relief Depth | | 7.0 MM All Rows = | 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 | | 20 | 12 | 24 | | | |
| | **Inspected By (Sign) & Date** | | Ravi. 20/12/24 | | | | | |

Satya 20/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner