10585

# 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. | | 15908 | 50/55 |
| 2 | Machined By | | V.T.L M/c Shop | Dy No. 68.9453 |
| 3 | Pallet Die No. | | 15784 (4.0) mm | Rev. 00 |
| 4 | Die Category | Drg. No. | Jet | |
| 5 | Out Side Diameter | Drg. No. | 790 mm, Step OD. 743.8 mm | Tapper 1° |
| 6 | Inside Diameter | Drg. No. | 630.14 mm | Step length. 23.3 |
| 7 | Width of Pellet Die | Drg. No. | 290.6 mm | Coder cut. 1.8 mm |
| 8 | Grooves as per Drawing | Drg. No. | 15.3 x 8 x 5 mm / 15.3 x 8 x 5 mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | Face Side 9 |
| 10 | Drilling Area Surface Smoothness | | ok | 0.8 mm Deep |
| 11 | Tapping Operator | | M/c Shop | Both Side |
| 12 | Tapping PCD | | 685 mm | Tapping M |
| 13 | Tapping Hole Diameter | | M20 Check by M20 Bolt | of Holes 16 |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | Both Side |
| 15 | Tapping Hole Depth | | Drill Depth 20.5 mm | Tapping Depth 18 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | Inspected By (Sign) & Date | | Ravi 01/9/25 | |
| 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. Go

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Ravi. 47 |
| 2 | External Relief Dia | 4.5 mm | Outside (23-3) | | Inner | | | |
| 3 | External Relief Depth | | 13 mm | | 5 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 | | 4 | 9 | 25 | | | |
| | Inspected By (Sign) & Date | | Ravi 4/9/25 | | | | | |

Sanjay 4/9/25

Reviewed by (Engineer-CNC)

Manager-QA