



# 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.                        |                        | 11285                                     | 50/65.5            |
| 2     | Machined By                           |                        | V.T.L. n/c. Shop                          | Drg No. 13.0.908   |
| 3     | Pallet Die No.                        |                        | 11155 (10.0)mm                            | Rev. 2.00          |
| 4     | Die Category                          | Drg. No.               | 58870                                     |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 640.3mm Step OD, 641.7mm                  | 652.3mm            |
| 6     | Inside Diameter                       | Drg. No.               | 508.8mm / 522.1mm / 539.7mm               | Tapper 3°          |
| 7     | Width of Pellet Die                   | Drg. No.               | 174.9mm                                   | Step length = 32mm |
| 8     | Grooves as per Drawing                | Drg. No.               | 30x21x8mm / 9x25mm                        | Under cut = 0.6mm  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok  |                    |
| 10    | Drilling Area Surface Smoothness      |                        | ok  |                    |
| 11    | Tapping Operator                      |                        | n/c. Shop                                 | [ Tapping No ]     |
| 12    | Tapping PCD                           |                        | 574mm                                     | [ of Holes = 4 ]   |
| 13    | Tapping Hole Diameter                 |                        | M16. Check by M16 Bolt                    |                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | One Side Tapping and Top Side 4 slot      |                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 30.8mm Tapping Depth = 28mm |                    |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                       |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                    |

|                            |                                |             |             |
|----------------------------|--------------------------------|-------------|-------------|
| Inspected By (Sign) & Date |                                | Ravi 1/3/24 | [ 4 SLOT ]  |
| 1                          | As per programme no.           |             | 51.5mm long |
| 2                          | Gun Drilling Work Completed On |             | 28mm width  |
| 3                          | Hole Finish In Gun Drilling    | Marked      | 15mm Deep   |
| 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 = 6° |
| 2                          | External Relief Dia                        | 11.0mm      | All Reqs     |  |  |  |  |              |
| 3                          | External Relief Depth                      |             | 15.5mm       |  |  |  |  |              |
| 4                          | Inspection Done Before Hardening By (Name) |             | Ravi         |  |  |  |  |              |
| 5                          | Material Sent For Hardening By (Name)      |             | Lark Fornare |  |  |  |  |              |
| 6                          | Material Sent For Hardening On Date        |             | 1 3 24       |  |  |  |  |              |
| Inspected By (Sign) & Date |  | Ravi 1/3/24 |              |  |  |  |  |              |

Reviewed by (Engineer-CNC)

Manager-QA