



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|------------------------------------|----------------------------------|
| 1 | Work Order No. | | 11970 | 20/66 |
| 2 | Machined By | | V.T.L M/C SHOP | Drg No- LSD-109 |
| 3 | Pallet Die No. | | 1PP85 (6.0mm) | (Rev01) |
| 4 | Die Category | Drg. No. | H. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 680.2mm | Step on 2 693mm Step length 31mm |
| 6 | Inside Diameter | Drg. No. | 548.12mm | Tapper 8° |
| 7 | Width of Pellet Die | Drg. No. | 195mm | Under cot. 2.45mm |
| 8 | Grooves as per Drawing | Drg. No. | 32 x 7 x 8mm / 32 x 7 x 8mm | 4 x 3 Face side 4 x 3 |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | Tapping No. of |
| 10 | Drilling Area Surface Smoothness | | ok | Holes 4 Both |
| 11 | Tapping Operator | | M/C SHOP | Side |
| 12 | Tapping PCD | | 619mm | |
| 13 | Tapping Hole Diameter | | M16 Check by M16 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth - 33.2 Tapping Depth - | 31.6mm |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ramanpreet Singh 29/5/24

| | | | | |
|---|--------------------------------|--------|----|--|
| 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-30

| | | | | | | | | | | |
|---|--|-------|------------------|---|----|--|--|--|--|--------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | | Row-12 |
| 2 | External Relief Dia | 7.5mm | All Lines | | | | | | | |
| 3 | External Relief Depth | | 46mm | | | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ramanpreet Singh | | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | | | |
| 6 | Material Sent For Hardening On Date | | 29 | 5 | 24 | | | | | |

Inspected By (Sign) & Date

Ramanpreet Singh 29/5/24

Satya 29/5/24

Reviewed by (Engineer-CNC)

Manager-QA