



# 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.                        |                        | 11500                             | 32/15.5 ✓                          |
| 2     | Machined By                           |                        | V.T.L M/C Shop                    | Drg No- LSP-871                    |
| 3     | Pallet Die No.                        |                        | 12527 (10.0mm)                    | (Revolt)                           |
| 4     | Die Category                          | Drg. No.               | M. Jumbo                          |                                    |
| 5     | Out Side Diameter                     | Drg. No.               | 711mm Step od-725mm               | Step Length-34.1mm                 |
| 6     | Inside Diameter                       | Drg. No.               | 580.1mm                           | Taper-5°                           |
| 7     | Width of Pellet Die                   | Drg. No.               | 193mm                             | Under cut-4.2mm                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 31 X 4.5 X 6mm / 31 X 4.5 X 6mm   | 4 X 6 ✓                            |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                | [Tapping No. of Holes 4 Both Side] |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                |                                    |
| 11    | Tapping Operator                      |                        | M/C Shop                          |                                    |
| 12    | Tapping PCD                           |                        | 650mm                             | Face side Step                     |
| 13    | Tapping Hole Diameter                 |                        | M16 check by M16 Bolt             | 1mm deep                           |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                | Both Side ✓                        |
| 15    | Tapping Hole Depth                    |                        | Drill Depth-36.4mm Tapping Depth- | 34mm                               |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                               |                                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                |                                    |

Inspected By (Sign) & Date Ramanpreet Singh 05/6/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 - 60°

|   |  |        |                  |   |    |  |  |  |       |
|---|--|--------|------------------|---|----|--|--|--|-------|
| 1 | Counter Sinking Depth & Finish             | ok     |                  |   |    |  |  |  | Row-8 |
| 2 | External Relief Dia                        | 11.0mm | 11 Holes         |   |    |  |  |  |       |
| 3 | External Relief Depth                      |        | 33.5mm           |   |    |  |  |  |       |
| 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        |        | 05               | 6 | 24 |  |  |  |       |

Inspected By (Sign) & Date Ramanpreet Singh 05/6/24

Satguru  
5/6/24

Reviewed by (Engineer-CNC)

Manager-QA