

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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. | | | |
| 2 | Machined By | | 12134 | 32/39 |
| 3 | Pallet Die No. | | V.T.L M/C SHOP | Drg No - LSD 937 |
| 4 | Die Category | Drg. No. | 11994 (3-2mm) | (Revo) |
| 5 | Out Side Diameter | Drg. No. | MJEU | |
| 6 | Inside Diameter | Drg. No. | 678mm, Step of- 692mm | Step Length-20mm |
| 7 | Width of Pellet Die | Drg. No. | 600.12mm | Under cut-7mm |
| 8 | Grooves as per Drawing | Drg. No. | 265mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 15 X 8 X 7mm / 15 X 8 X 7mm | |
| 10 | Drilling Area Surface Smoothness | | ok | [Tapping No. of Holes 16 Both Side] |
| 11 | Tapping Operator | | M/C SHOP | |
| 12 | Tapping PCD | | 840mm | |
| 13 | Tapping Hole Diameter | | M 20 Check by M 20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth - 20.4mm Tapping Depth - 13.6mm | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date Ramanpreet Singh 14/06/24

| | | | | |
|---|--------------------------------|--------|----|--|
| 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 Counted - 60° Row - 45

| | | | | |
|---|--|-------|------------------|--|
| 1 | Counter Sinking Depth & Finish | ok | | |
| 2 | External Relief Dia | 3.8mm | 7mm All Rows | |
| 3 | External Relief Depth | | | |
| 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 | | 14 06 24 | |

Inspected By (Sign) & Date Ramanpreet Singh 14/06/24

Satyajit
14/6/24,
Reviewed by (Engineer-CNC)

Manager-QA