



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. | | 12215 | 36/45 |
| 2 | Machined By | | V.T.L M/C Shop | Drg No- LSP 302 |
| 3 | Pallet Die No. | | 12670 (6.0mm) | Creval |
| 4 | Die Category | Drg. No. | SEW | |
| 5 | Out Side Diameter | Drg. No. | 510mm Step od- 491mm | Step length-16.5mm |
| 6 | Inside Diameter | Drg. No. | 420.12mm | |
| 7 | Width of Pellet Die | Drg. No. | 173mm | |
| 8 | Grooves as per Drawing | Drg. No. | 10x8.5x5mm / 10x8.5x5mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | Tapping No. of Holes 8 - Both side |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/C Shop | |
| 12 | Tapping PCD | | 455mm | |
| 13 | Tapping Hole Diameter | | 3/4" Check by 3/4" Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth- 20.5mm Tapping Depth- 18.5mm | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date Ramanjeet Singh 20/06/24

| | | | |
|---|--------------------------------|--------|----|
| 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 Counter-62

| | | | | | | | | | |
|---|--|-------|-----------------|-------|----|--|--|--|--------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | Row-17 |
| 2 | External Relief Dia | 6.5mm | outside (2-2) | Innet | | | | | |
| 3 | External Relief Depth | | 15mm | 9mm | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ramanjeet Singh | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | | |
| 6 | Material Sent For Hardening On Date | | 20 | 06 | 24 | | | | |

Inspected By (Sign) & Date Ramanjeet Singh 20/06/24

Sats
20/06/24

Reviewed by (Engineer-CNC)

Manager-QA