



# Lark Engineering Company (India) Pvt. Ltd.

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

7857

|           |              |
|-----------|--------------|
| 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.                        |                        | 12518                      | 40/50              |
| 2     | Machined By                           |                        | V.T.L. n/c Shop            | Dry Hole Lark 355  |
| 3     | Pallet Die No.                        |                        | 12615 (4.0) n/c            | 33-10              |
| 4     | Die Category                          | Drg. No.               | 2 extra side               |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 620 n/c, step 0.2, 612 n/c | step length 9.5    |
| 6     | Inside Diameter                       | Drg. No.               | 520.12 n/c                 |                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 n/c                    |                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 n/c / 13x2x5 n/c    |                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                         |                    |
| 10    | Drilling Area Surface Smoothness      |                        | ok                         |                    |
| 11    | Tapping Operator                      |                        | n/c Shop                   |                    |
| 12    | Tapping PCD                           |                        | 565 n/c                    |                    |
| 13    | Tapping Hole Diameter                 |                        | H20, check by H2-Ball      |                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                         |                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 2.4 n/c        | Tapping Depth 18.5 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                        |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                         |                    |

### Inspected By (Sign) & Date

Ravi 19/7/24

|   |                                |        |       |  |
|---|--------------------------------|--------|-------|--|
| 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

|   |  |         |               |        |    |  |  |               |
|---|--|---------|---------------|--------|----|--|--|---------------|
| 1 | Counter Sinking Depth & Finish             | OK      |               |        |    |  |  | Counter = 60° |
| 2 | External Relief Dia                        | 4.3 n/c | Outside (2-3) | Inner  |    |  |  | Row = 31      |
| 3 | External Relief Depth                      |         | 14 n/c        | 10 n/c |    |  |  |               |
| 4 | Inspection Done Before Hardening By (Name) |         |               |        |    |  |  | Ravi          |
| 5 | Material Sent For Hardening By (Name)      |         |               |        |    |  |  | Lark Furnace  |
| 6 | Material Sent For Hardening On Date        |         | 19            | 7      | 24 |  |  |               |

### Inspected By (Sign) & Date

Ravi 19/7/24

Satyam 20/7/24  
Reviewed by (Engineer-CNC)

Manager-QA