



# 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.                        |                        | 13655                   | 45/50                                 |
| 2     | Machined By                           |                        | V.T.L. n/c              | Step                                  |
| 3     | Pallet Die No.                        |                        | 13663(6.0) n/c          | Rev = 00                              |
| 4     | Die Category                          | Drg. No.               | Centre side             |                                       |
| 5     | Out Side Diameter                     | Drg. No.               | 620 n/c                 | Step 00 = Tapper = 12°                |
| 6     | Inside Diameter                       | Drg. No.               | 520.12 n/c              | Step length = 18.5                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 n/c                 |                                       |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 n/c / 13x8x5 n/c |                                       |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                      |                                       |
| 10    | Drilling Area Surface Smoothness      |                        | ok                      |                                       |
| 11    | Tapping Operator                      |                        | n/c                     | Step                                  |
| 12    | Tapping PCD                           |                        | 565 n/c                 | Tapping No of Holes = 12<br>Both Side |
| 13    | Tapping Hole Diameter                 |                        | M20 Check by M20 Ball   |                                       |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                      |                                       |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 20.3      | Tapping Depth = 18.6                  |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                     |                                       |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                      |                                       |

Inspected By (Sign) & Date *Ravi 20/11/24*

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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°<br>Rev = 23 |
| 2 | External Relief Dia                        | 6.5 n/c | Outside (3-3)       | Inner |    |  |  |                           |
| 3 | External Relief Depth                      |         | 11 n/c              | 5 n/c |    |  |  |                           |
| 4 | Inspection Done Before Hardening By (Name) |         | <i>Ravi</i>         |       |    |  |  |                           |
| 5 | Material Sent For Hardening By (Name)      |         | <i>Lark Burnace</i> |       |    |  |  |                           |
| 6 | Material Sent For Hardening On Date        |         | 20                  | 12    | 24 |  |  |                           |

Inspected By (Sign) & Date *Ravi 20/11/24*

*Sats*  
20/11/24  
Reviewed by (Engineer-CNC)

Manager-QA