



# 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.                        |                        | 13650 ✓                                 | 47/50 ✓ 6955                             |
| 2     | Machined By                           |                        | V.T.L. n/c Shop                         | Dy. n/c Lark 570                         |
| 3     | Pallet Die No.                        |                        | 13662 (4.5) n/c                         |  |
| 4     | Die Category                          | Drg. No.               | Carterside ✓                            |  |
| 5     | Out Side Diameter                     | Drg. No.               | 620 n/c Step 002 612 n/c                | Step length 2.185                        |
| 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 / 13x8x5 n/c                 |  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                      |  |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                      |  |
| 11    | Tapping Operator                      |                        | n/c Shop                                | [ Tapping No. of holes 12<br>Rota Side ] |
| 12    | Tapping PCD                           |                        | 565 n/c                                 |  |
| 13    | Tapping Hole Diameter                 |                        | M20 Check by M20 Bolt                   |  |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                      |  |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.9 n/c Tapping Depth 18.5 |  |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                     |  |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                      |  |

### Inspected By (Sign) & Date

Ravi 23/12/24

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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, Go |                 |       |         |
|---|--|-------------|-----------------|-------|---------|
| 1 | Counter Sinking Depth & Finish             | ok          |                 |       | Ravi 23 |
| 2 | External Relief Dia                        | 5.0 n/c     | 20 B side (3-3) | Inner |         |
| 3 | External Relief Depth                      |             | 7 n/c           | 3 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        |             | 23              | 12    | 24      |

### Inspected By (Sign) & Date

Ravi 23/12/24

Satish 23/12/24

Reviewed by (Engineer-CNC)

Manager-QA