



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|-----------------------------|---|
| 1 | Work Order No. | | 13599 ✓ | 35/50 ✓ |
| 2 | Machined By | | V.T.L H/C Shop | Dry Hole 1.80 20597 |
| 3 | Pallet Die No. | | 12920 (3.0) H/C ✓ | Rev 2.00 ✓ |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 680 H/C, Step OD, 680 H/C ✓ | Tapper 2.12 ✓ |
| 6 | Inside Diameter | Drg. No. | 580.12 H/C ✓ | Step length 5.45 ✓ |
| 7 | Width of Pellet Die | Drg. No. | 266 H/C ✓ | Under cut 1.14 ✓ |
| 8 | Grooves as per Drawing | Drg. No. | 28.5 x 6 x 12 H/C ✓ | 28.5 x 6 x 12 H/C ✓ |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | H/C Shop | [Tapping No. of Holes = 12 Both Side] |
| 12 | Tapping PCD | | 630 H/C ✓ | |
| 13 | Tapping Hole Diameter | | M16 - Check by H/C Bolt ✓ | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth 25.2 H/C ✓ | Tapping Depth 23.5 ✓ |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 31/7/25

| | | | |
|---|--------------------------------|--------|-------|
| 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 | | | | | | | | Countersink ✓ |
| 2 | External Relief Dia | 3.3 H/C | Outside (3-3) | | Inner | | | | | |
| 3 | External Relief Depth | | 2.1 H/C | | 15 H/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 | | 3 | 1 | 25 | | | | | |

Inspected By (Sign) & Date

Ravi 31/7/25

Reviewed by (Engineer-CNC)

Manager-QA