



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. | | 13776 ✓ | 22/02/20 ✓ |
| 2 | Machined By | | V.T.L. N/C. Shop | Operator U.D. = 700 |
| 3 | Pallet Die No. | | 13917 (G.O) ✓ | Row = 03 ✓ |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 730mm, 3 step OD = 739mm | Step length 30mm |
| 6 | Inside Diameter | Drg. No. | 578.12mm, 632mm | 18.5mm |
| 7 | Width of Pellet Die | Drg. No. | 219mm | Under cot = 1mm |
| 8 | Grooves as per Drawing | Drg. No. | 75x8x8mm / 53x8x8mm | |
| 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 = 6 |
| 12 | Tapping PCD | | 650mm ✓ | |
| 13 | Tapping Hole Diameter | | MIG = Check by MIG Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | One Side Tapping and Tread Side One Slot | |
| 15 | Tapping Hole Depth | | Drill Depth = 40.2mm | Tapping Depth = 38.5 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | Maintain A & J Hard |
| Inspected By (Sign) & Date | | | Ravi 9/1/25 | 1 Slot ↓ |
| 1 | As per programme no. | | _____ | 32.1mm width 19mm Deep |
| 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 Row = 8 |
| 2 | External Relief Dia | 6.5mm / 7.0mm | 6.5mm All Rows = 59mm ✓ | |
| 3 | External Relief Depth | | 7.0mm All Rows = 37mm ✓ | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | |
| 6 | Material Sent For Hardening On Date | | 9 / 1 / 25 | |
| Inspected By (Sign) & Date | | | Ravi 9/1/25 | |

Reviewed by (Engineer-CNC)

Manager-QA