



# 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.                        |                        | 13894                   | 40/40                              |
| 2     | Machined By                           |                        | V.T.L. H/c. Shop        | Dy. No. Lark 9210                  |
| 3     | Pallet Die No.                        |                        | 13230 (4.5) H/c         |                                    |
| 4     | Die Category                          | Drg. No.               | Senior                  |                                    |
| 5     | Out Side Diameter                     | Drg. No.               | 499.8 H/c               | Step length 17.5                   |
| 6     | Inside Diameter                       | Drg. No.               | 420.12 H/c              |                                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 H/c                 |                                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x8x3 H/c   12x8x3 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. B. Both Side |
| 12    | Tapping PCD                           |                        | 454 H/c                 |                                    |
| 13    | Tapping Hole Diameter                 |                        | M20 C. back by M20 Bolt |                                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                      |                                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 18.2 H/c    | Tapping Depth 16.6 H/c             |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                     |                                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                      |                                    |

Inspected By (Sign) & Date Ravi 16/1/25

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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      |               |   |              |  |  | Counter = 60° |
| 2 | External Relief Dia                        | 5.0 H/c | Outside (2-2) |   | Inner        |  |  | Rev. 18       |
| 3 | External Relief Depth                      |         | 5 H/c         |   | Nil          |  |  |               |
| 4 | Inspection Done Before Hardening By (Name) |         |               |   | Ravi         |  |  |               |
| 5 | Material Sent For Hardening By (Name)      |         |               |   | Lark furnace |  |  |               |
| 6 | Material Sent For Hardening On Date        |         | 16            | 1 | 25           |  |  |               |

Inspected By (Sign) & Date Ravi 16/1/25

Reviewed by (Engineer-CNC) [Signature] 16/1/25

Manager-QA