



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

9/11

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|-----------------------------|----------------------------------|
| 1 | Work Order No. | | 14005 | 30/40 |
| 2 | Machined By | | V.T.L. n/c. Shop | Dy No. 13.0-31 |
| 3 | Pallet Die No. | | 13304(3.0) mm | Revol |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 5mm mm, Step OD = 4.99 mm | Tapped 12 |
| 6 | Inside Diameter | Drg. No. | 4.20 ± 0.12 mm | Step length 17 mm |
| 7 | Width of Pellet Die | Drg. No. | 158 mm | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 mm 12x8x3 mm | |
| 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 8 Both Side |
| 12 | Tapping PCD | | 454 mm | |
| 13 | Tapping Hole Diameter | | 0.34" - Check by 0.34" Ball | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 18.3 mm | Tapping Depth 0.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 30/1/25

| | | | |
|---|--------------------------------|--------|----|
| 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 | | | | | Count 22-60 |
| 2 | External Relief Dia | 0.5 mm | outside (2-2) | inner | | | Var = 25 |
| 3 | External Relief Depth | | 13 mm | 10 mm | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Porrae | | | | |
| 6 | Material Sent For Hardening On Date | | 30 | 1 | 25 | | |

Inspected By (Sign) & Date

Ravi 30/1/25

Reviewed by (Engineer-CNC)

Manager-QA