

9152



# 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.                        |                        | 13984 ✓                           | 82/36/60 ✓                           |
| 2     | Machined By                           |                        | V. T. L. n/c Shop                 | Dy. No. 130 ✓                        |
| 3     | Pallet Die No.                        |                        | 13845 (40) ✓                      | Pass ✓                               |
| 4     | Die Category                          | Drg. No.               | Jumbo                             |                                      |
| 5     | Out Side Diameter                     | Drg. No.               | 78mm, Step O.D. 792mm             | Step Length = 365                    |
| 6     | Inside Diameter                       | Drg. No.               | 660.12mm (Bore 653.3mm) (A)       |                                      |
| 7     | Width of Pellet Die                   | Drg. No.               | 393.9mm ✓                         |                                      |
| 8     | Grooves as per Drawing                | Drg. No.               | 21.5 x 8 x 8mm / 21.5 x 8 x 3mm ✓ |                                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                |                                      |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                |                                      |
| 11    | Tapping Operator                      |                        | n/c Shop                          |                                      |
| 12    | Tapping PCD                           |                        | 725mm ✓                           | [ Tapping of Holes 12<br>Back Side ] |
| 13    | Tapping Hole Diameter                 |                        | M202 Check by M20 Bolt            |                                      |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                |                                      |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 31.3mm                | Tapping Depth 29.5                   |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                               |                                      |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                |                                      |

**Inspected By (Sign) & Date**

Ravi 5/2/25

|   |                                |        |                        |
|---|--------------------------------|--------|------------------------|
| 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 - 2 Hole Closed (A) |

**Note : Mark the defective holes/Missed holes with the help of Permanent Marker**

Counter 30°

|   |  |                 |       |                   |    |  |  |  |  |
|---|--|-----------------|-------|-------------------|----|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok              |       |                   |    |  |  |  |  |
| 2 | External Relief Dia                        | 4.8mm / 5.0mm ✓ | 4.8mm | All Rows = 32mm ✓ |    |  |  |  |  |
| 3 | External Relief Depth                      |                 | 5.0mm | All Rows = 24mm ✓ |    |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |                 |       | Ravi              |    |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |                 |       | Lark Furnace      |    |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |                 | 5     | 2                 | 25 |  |  |  |  |

**Inspected By (Sign) & Date**

Ravi 5/2/25

Satish 5/2/25

Reviewed by (Engineer-CNC)

Manager-QA