



# 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.                        |                        | 13060 ✓                         | 30/50 ✓                             |
| 2     | Machined By                           |                        | V.T.L. H/c Shop                 | Drg No. L20014805                   |
| 3     | Pallet Die No.                        |                        | 12006 (3-0) H/c ✓               | Revised ✓                           |
| 4     | Die Category                          | Drg. No.               | M700                            |                                     |
| 5     | Out Side Diameter                     | Drg. No.               | 701 H/c, Step OD = Tapper 12° ✓ |                                     |
| 6     | Inside Diameter                       | Drg. No.               | 600.12 H/c ✓                    | Step length 12.1 ✓                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 265 H/c ✓                       |                                     |
| 8     | Grooves as per Drawing                | Drg. No.               | 15x8x7 H/c / 15x8x7 H/c ✓       |                                     |
| 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 10<br>Back side |
| 12    | Tapping PCD                           |                        | 640 H/c ✓                       |                                     |
| 13    | Tapping Hole Diameter                 |                        | M20 = Check by M20 Bolt ✓       |                                     |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                              |                                     |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.4 H/c            | Tapping Depth 18.5 H/c              |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                             |                                     |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                              |                                     |

### Inspected By (Sign) & Date

Ravi 3/2/25

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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    |

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

Counter 260

|   |  |         |               |   |              |  |  |  |
|---|--|---------|---------------|---|--------------|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok      |               |   |              |  |  |  |
| 2 | External Relief Dia                        | 3.5 H/c | Outside (3-3) |   | Inner        |  |  |  |
| 3 | External Relief Depth                      |         | 23 H/c        |   | 20 H/c       |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |         |               |   | Ravi         |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |         |               |   | Lark Forward |  |  |  |
| 6 | Material Sent For Hardening On Date        |         | 3             | 2 | 25           |  |  |  |

### Inspected By (Sign) & Date

Ravi 3/2/25

Reviewed by (Engineer-CNC)   
 Seta 3/2/25

Manager-QA