



# 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.                        |                        | 13978                                     | 30/32/00                          |
| 2     | Machined By                           |                        | V.T.L. N/C Shop                           | Dy. No. 13.02.797                 |
| 3     | Pallet Die No.                        |                        | 13846 (4.0) H                             | Revised                           |
| 4     | Die Category                          | Drg. No.               | Jumbo                                     |                                   |
| 5     | Out Side Diameter                     | Drg. No.               | 780 H / Step 00, 792 H / Step length 26.5 |                                   |
| 6     | Inside Diameter                       | Drg. No.               | 660.14 H / 660.2 H (A)                    | Under cut 6 H                     |
| 7     | Width of Pellet Die                   | Drg. No.               | 324 H                                     |                                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 21.5 x 8 x 8 H / 21.5 x 8 x 8 H           |                                   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK  |                                   |
| 10    | Drilling Area Surface Smoothness      |                        | OK  |                                   |
| 11    | Tapping Operator                      |                        | N/C Shop                                  | Tapping dia of holes 12 Both Side |
| 12    | Tapping PCD                           |                        | 725 H                                     |                                   |
| 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 31.4 H / Tapping Depth 29.5   |                                   |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                       |                                   |
| 17    | Visual Inspection Before Gun Drilling |                        | OK  |                                   |

Inspected By (Sign) & Date

Ravi 6/2/25

|   |                                |        |                     |
|---|--------------------------------|--------|---------------------|
| 1 | As per programme no.           |        | _____               |
| 2 | Gun Drilling Work Completed On |        | _____               |
| 3 | Hole Finish In Gun Drilling    | Marked | OK (A)              |
| 4 | Defective Holes (If Any)       |        | No - 3 Holes Closed |

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

Counter 90

|   |  |               |                |       |    |  |  |              |
|---|--|---------------|----------------|-------|----|--|--|--------------|
| 1 | Counter Sinking Depth & Finish             | OK            |                |       |    |  |  | Ravi 47      |
| 2 | External Relief Dia                        | 4.8 H / 5.0 H | 4.8 H All Rows | 230 H |    |  |  |              |
| 3 | External Relief Depth                      | ✓             | 5.0 H All Rows | 22 H  |    |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |               |                |       |    |  |  | Ravi         |
| 5 | Material Sent For Hardening By (Name)      |               |                |       |    |  |  | Lark Forcare |
| 6 | Material Sent For Hardening On Date        |               | 6              | 2     | 25 |  |  |              |

Inspected By (Sign) & Date

Ravi 6/2/25