



# 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.                             |                        | 14124                                    | 38150                                 |
| 2  | Machined By                                |                        | V.T.L. n/c Shop                          | Drg. No. 13.9.406                     |
| 3  | Pallet Die No.                             |                        | 13837 (4.0) n/c                          | Rev. No.                              |
| 4  | Die Category                               | Drg. No.               | End sawide                               |                                       |
| 5  | Out Side Diameter                          | Drg. No.               | 620.44 Step CD 620.44                    | Tapper 12°                            |
| 6  | Inside Diameter                            | Drg. No.               | 520.12 n/c                               | Step length 18 n/c                    |
| 7  | Width of Pellet Die                        | Drg. No.               | 222.44                                   | Under cut 1 n/c                       |
| 8  | Grooves as per Drawing                     | Drg. No.               | 13x8x5 n/c   13x8x5 n/c                  |                                       |
| 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<br>Bothe Side |
| 12   | Tapping PCD                                |                        | 565.44                                   |                                       |
| 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 20.34 Tapping Depth 18.5 n/c |                                       |
| 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                                       |                                       |
| 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<br>Rows 31                 |
| 2  | External Relief Dia                        | 4.5 n/c                | Outside 2-3                              | Inner                                 |
| 3  | External Relief Depth                      |                        | 16 n/c                                   | 12 n/c                                |
| 4  | Inspection Done Before Hardening By (Name) |                        | Ravi                                     |                                       |
| 5  | Material Sent For Hardening By (Name)      |                        | Lark Furnace                             |                                       |
| 6  | Material Sent For Hardening On Date        |                        | 6  | 25                                    |
| Inspected By (Sign) & Date   |  |                        | Ravi 6/2/25                              |                                       |

Reviewed by (Engineer-CNC)

Manager-QA