

9079



# 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.                        |                        | 14032 ✓                       | 45/52/655                         |
| 2     | Machined By                           |                        | V.T.L. H/c Shop               | Dy. Insp. Lark 3310               |
| 3     | Pallet Die No.                        |                        | 13739 (B.O) H/c               |                                   |
| 4     | Die Category                          | Drg. No.               | Extruder die                  |                                   |
| 5     | Out Side Diameter                     | Drg. No.               | 619.9 H/c Step OD = 611.9 H/c | Step length 19.4                  |
| 6     | Inside Diameter                       | Drg. No.               | 520.12 H/c                    |                                   |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 H/c                       |                                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 H/c   13x8x5 H/c       |                                   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                            |                                   |
| 10    | Drilling Area Surface Smoothness      |                        | OK                            |                                   |
| 11    | Tapping Operator                      |                        | H/c Shop                      | Tapping H/c of holes 12 Both Side |
| 12    | Tapping PCD                           |                        | 565 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 20.3 H/c          | Tapping Depth 18.6                |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                           |                                   |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                            |                                   |

### Inspected By (Sign) & Date

Ravi 25/1/25

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

Counter = 60  
Row = 23

|   |  |         |               |   |       |  |  |
|---|--|---------|---------------|---|-------|--|--|
| 1 | Counter Sinking Depth & Finish             | OK      |               |   |       |  |  |
| 2 | External Relief Dia                        | 6.5 H/c | Outside (3-3) |   | Inner |  |  |
| 3 | External Relief Depth                      |         | 11 H/c        |   | 5 H/c |  |  |
| 4 | Inspection Done Before Hardening By (Name) |         | Ravi          |   |       |  |  |
| 5 | Material Sent For Hardening By (Name)      |         | Lark Bommace  |   |       |  |  |
| 6 | Material Sent For Hardening On Date        |         | 25            | 1 | 25    |  |  |

### Inspected By (Sign) & Date

Ravi 25/1/25

Satyam 25/1/25

Reviewed by (Engineer-CNC)

Manager-QA