



# 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.                        |                        | 14092 ✓                 | 98/38/66 ✓            |
| 2     | Machined By                           |                        | V.T.L n/c Shop          | Dy. No. 13.0.69       |
| 3     | Pallet Die No.                        |                        | 14395(6.0)M ✓           | Rev. 03               |
| 4     | Die Category                          | Drg. No.               | M. Jumbo                |                       |
| 5     | Out Side Diameter                     | Drg. No.               | 680.7mm ✓               | 692.4mm ✓             |
| 6     | Inside Diameter                       | Drg. No.               | 548.12mm (Bot: 548.4mm) | Tappers 8°            |
| 7     | Width of Pellet Die                   | Drg. No.               | 195mm                   | Step length 31mm      |
| 8     | Grooves as per Drawing                | Drg. No.               | 32x7x9.2mm   32x7x9.2mm | Undercut 2.5mm        |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                      |                       |
| 10    | Drilling Area Surface Smoothness      |                        | ok                      | Face Side Step        |
| 11    | Tapping Operator                      |                        | n/c Shop                | 2mm Deep Bot Side     |
| 12    | Tapping PCD                           |                        | 619mm ✓                 |                       |
| 13    | Tapping Hole Diameter                 |                        | NIG ✓                   | Tapping No of holes 2 |
| 14    | Tapping On Second Side                | Half pitch of 1st side | Check by NIG Bolt       | Bot Side              |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 33.4mm      | Tapping Depth 31.6mm  |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                     |                       |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                      |                       |

### Inspected By (Sign) & Date

Rasi: 15/8/25

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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 = 35° |
| 2 | External Relief Dia                        | 6.5mm   7.0mm | 6.5mm All Rows = 38mm ✓ |   |    |  |  | Row = 12      |
| 3 | External Relief Depth                      |               | 7.0mm All Rows = 98mm ✓ |   |    |  |  |               |
| 4 | Inspection Done Before Hardening By (Name) |               | Rasi                    |   |    |  |  |               |
| 5 | Material Sent For Hardening By (Name)      |               | Lark Furnace            |   |    |  |  |               |
| 6 | Material Sent For Hardening On Date        |               | 15                      | 8 | 25 |  |  |               |

### Inspected By (Sign) & Date

Rasi: 15/8/25

Reviewed by (Engineer-CNC)

Manager-QA