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# 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. | | 14087 | 30/66 |
| 2 | Machined By | | V.T.L H/C Shop | Drg No. L.3.0-6.9 Rev-03 |
| 3 | Pallet Die No. | | 14032 (6.0) HH | |
| 4 | Die Category | Drg. No. | H. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 680.7 HH Step OD: 692.7 HH | Tapper = 3° |
| 6 | Inside Diameter | Drg. No. | 546.12 HH (Bore: 548.4 HH) | Step length: 31 HH |
| 7 | Width of Pellet Die | Drg. No. | 195 HH | Under cut: 2.5 HH |
| 8 | Grooves as per Drawing | Drg. No. | 32 x 7 x 9.2 HH / 32 x 7 x 9.2 HH | (4 no.) HH |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | Face Side Step 9 HH Deep Both Side |
| 11 | Tapping Operator | | H/C Shop | |
| 12 | Tapping PCD | | 619 HH | |
| 13 | Tapping Hole Diameter | | M16 = Check by M16 Bolt | Tapping No of Holes 2 Both Side |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 33.3 HH Tapping Depth 31.0 HH | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | **Inspected By (Sign) & Date** | | Ravi 22/2/25 | |
| 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 8° Rows 12 |
| 2 | External Relief Dia | 4.0 HH | All Rows | | | | | | |
| 3 | External Relief Depth | | | 36 HH | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | | |
| 6 | Material Sent For Hardening On Date | | 22 | 2 | 25 | | | | |
| | **Inspected By (Sign) & Date** | | Ravi 22/2/25 | | | | | | |

Satish 22/2/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner