



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter                       | Specification          | Observations               | Remarks                                |
|-------|---------------------------------------|------------------------|----------------------------|--|
| 1     | Work Order No.                        |                        | 14293                      | 36/50                                  |
| 2     | Machined By                           |                        | V.T.L H/C Shop             | Dy. No. 1.3.0.389                      |
| 3     | Pallet Die No.                        |                        | 12846(4.0) H/C             | Rev 2.00                               |
| 4     | Die Category                          | Drg. No.               | S8870                      |  |
| 5     | Out Side Diameter                     | Drg. No.               | 620 H/C Step 00. G92.0 H/C | Tapper 12°                             |
| 6     | Inside Diameter                       | Drg. No.               | 520.12 H/C                 | Step length 20 H/C                     |
| 7     | Width of Pellet Die                   | Drg. No.               | 190 H/C                    | Under 1.1 H/C                          |
| 8     | Grooves as per Drawing                | Drg. No.               | 15x5x3 H/C   15x5x3 H/C    |  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                         |  |
| 10    | Drilling Area Surface Smoothness      |                        | ok                         |  |
| 11    | Tapping Operator                      |                        | H/C Shop                   | Tapping No. of Holes - 12<br>Back Side |
| 12    | Tapping PCD                           |                        | 585 H/C                    |  |
| 13    | Tapping Hole Diameter                 |                        | H/C - Check by H/C Ball    |  |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                         |  |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 25.2 H/C       | Tapping Depth 28.5                     |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                        |  |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                         |  |

### Inspected By (Sign) & Date

Ravi 3/3/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 1 | As per programme no.           |        | ok |
| 2 | Gun Drilling Work Completed On |        | ok |
| 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

Coorden - 60

Rev 2.25

|   |  |         |               |   |        |  |              |
|---|--|---------|---------------|---|--------|--|--------------|
| 1 | Counter Sinking Depth & Finish             | ok      |               |   |        |  |              |
| 2 | External Relief Dia                        | 4.5 H/C | Outside (3-3) |   | Inner  |  |              |
| 3 | External Relief Depth                      |         | 18 H/C        |   | 14 H/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        |         | 3             | 3 | 25     |  |              |

### Inspected By (Sign) & Date

Ravi 3/3/25

Reviewed by (Engineer-CNC)

Manager-QA