



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. | | 14085 ✓ | 38/55 ✓ | |
| 2 | Machined By | | V.T.L. H/C Shop | Dy. M. L. G. 29/7/13 | |
| 3 | Pallet Die No. | | 14058 (3.0) ✓ | Revised | |
| 4 | Die Category | Drg. No. | Jumbo | | |
| 5 | Out Side Diameter | Drg. No. | 770 H/C ✓ Step OD = 793 H/C ✓ | Tapper 4° | |
| 6 | Inside Diameter | Drg. No. | 660.12 H/C ✓ | Step length 28 H/C | |
| 7 | Width of Pellet Die | Drg. No. | 324 H/C ✓ | Under cut 11.5 H/C | |
| 8 | Grooves as per Drawing | Drg. No. | 21.5 x 8 x 8 H/C / 21.5 x 8 x 8 H/C | | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | | |
| 10 | Drilling Area Surface Smoothness | | ok | | |
| 11 | Tapping Operator | | H/C Shop | Tapping Holes of Holes 16 Both Side | |
| 12 | Tapping PCD | | 785 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 30.2 H/C | Tapping Depth 28.6 H/C | |
| 16 | Perpendicularity of Tapped Hole | | yes | | |
| 17 | Visual Inspection Before Gun Drilling | | ok | | |
| Inspected By (Sign) & Date | | | Ravi 6/3/25 | | |
| 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 Sink 58 | |
| 2 | External Relief Dia | 3.5 H/C | outside (3-3) | inner | |
| 3 | External Relief Depth | | 23 H/C | 17 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 | | 6 | 3 | 25 |
| Inspected By (Sign) & Date | | | Ravi 6/3/25 | | |

Reviewed by (Engineer-CNC)

Manager-QA