

9347



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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. | | 14387 ✓ | 27/40 ✓ |
| 2 | Machined By | | V. T. L. H/O Shop | Dry H/O L. 2. 01 5062 |
| 3 | Pallet Die No. | | 13977 (3.0) H/O | 2002 00 ✓ |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 500 H/O, Step 002 498.8 H/O | Tapper 12° |
| 6 | Inside Diameter | Drg. No. | 420.12 H/O | Step length 2.8 H/O |
| 7 | Width of Pellet Die | Drg. No. | 158 H/O ✓ | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 H/O / 12x8x3 H/O | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | H/O Shop | |
| 12 | Tapping PCD | | 454 H/O ✓ | Tapping H/O of Hole 8 Bolt Side |
| 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/O | Tapping Depth 18.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 10/3/25

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

Counter Bo
60.24

| | | | | | | | |
|---|--|---------|---------------|---|--------------|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | |
| 2 | External Relief Dia | 3.5 H/O | outside (2.2) | | Inner | | |
| 3 | External Relief Depth | | 16 H/O | | 13 H/O | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Furnace | | |
| 6 | Material Sent For Hardening On Date | | 20 | 3 | 25 | | |

Inspected By (Sign) & Date

Ravi 10/3/25

Satya 10/3/25

Reviewed by (Engineer-CNC)

Manager-QA