



Lark Engineering Company (India) Pvt. Ltd.

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

9361

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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. | | 14408 ✓ | 40/50 ✓ |
| 2 | Machined By | | V.T.L. HLC Shop | Drg. No. 1.20.9980 |
| 3 | Pallet Die No. | | 14168 (4.5) HLC | Rev. 2.00 ✓ |
| 4 | Die Category | Drg. No. | External | |
| 5 | Out Side Diameter | Drg. No. | 619.8 HLC | Tapp. 12" |
| 6 | Inside Diameter | Drg. No. | 520.12 HLC | Step length 18.5 |
| 7 | Width of Pellet Die | Drg. No. | 222 HLC | |
| 8 | Grooves as per Drawing | Drg. No. | 13x8x5 HLC 13x8x5 HLC | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | HLC Shop | Tapping No. of Holes: 12 Both Side |
| 12 | Tapping PCD | | 565 HLC | |
| 13 | Tapping Hole Diameter | | M2.0 Check by M2.0 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 20.3 HLC | Tapping Depth 18.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 11/3/25

| | | | |
|---|--------------------------------|--------|----|
| 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 60

| | | | | | | | | | |
|---|--|---------|---------------|----|--------|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | |
| 2 | External Relief Dia | 4.8 HLC | Outside (3-3) | | Inner | | | | |
| 3 | External Relief Depth | | 15 HLC | | 10 HLC | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | |
| 6 | Material Sent For Hardening On Date | | 11 | 03 | 25 | | | | |

Inspected By (Sign) & Date

Ravi 11/3/25

(Signature)
11/3/25

Reviewed by (Engineer-CNC)

Manager-QA