



# 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.                             |                        | 14543                   | 36/50                |
| 2                                                                              | Machined By                                |                        | V.T.L. n/c Shop         | Drg No. 13.D.450     |
| 3                                                                              | Pallet Die No.                             |                        | 13496(3.0)mm            | Rev. 00              |
| 4                                                                              | Die Category                               | Drg. No.               | 790                     |                      |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 730mm, Step 00, 742.4mm | Tapping 10           |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 630.12mm                | Step length 23mm     |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 290mm                   | Under cut = 6.8mm    |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15x8x5mm   15x8x5mm     |                      |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                      |                      |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                      |                      |
| 11                                                                             | Tapping Operator                           |                        | n/c Shop                | Tapping n/c          |
| 12                                                                             | Tapping PCD                                |                        | 685mm                   | of holes 16          |
| 13                                                                             | Tapping Hole Diameter                      |                        | M20, Check by M20 Bolt  | Back Side            |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                      |                      |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.2mm      | Tapping Depth 186    |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                     |                      |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                      |                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Raw: 18/3/25            |                      |
| 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 Raw: 52 |
| 2                                                                              | External Relief Dia                        | 3.5mm                  | 20 Side (3-3)           | Inner                |
| 3                                                                              | External Relief Depth                      |                        | 20mm                    | 14mm                 |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Raw                     |                      |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace            |                      |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 18 3 25                 |                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Raw: 18/3/25            |                      |

Reviewed by (Engineer-CNC)

Manager-QA