

# Lark Engineering Company (India) Pvt. Ltd.

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

## Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9530

| Check Parameter                                                                | Specification          | Observations                  | Remarks                            |
|--------------------------------------------------------------------------------|------------------------|-------------------------------|------------------------------------|
| 1 Work Order No.                                                               |                        | 14426                         | 37/40                              |
| 2 Machined By                                                                  |                        | UTL - m/c Shop                | Drg No Lark 874                    |
| 3 Pallet Die No.                                                               |                        | 13245 (3.0mm)                 |                                    |
| 4 Die Category                                                                 | Drg. No.               | Senior                        |                                    |
| 5 Out Side Diameter                                                            | Drg. No.               | 500 mm                        | Step 00. 490.9 mm Step length 18.5 |
| 6 Inside Diameter                                                              | Drg. No.               | 420.1 mm                      |                                    |
| 7 Width of Pellet Die                                                          | Drg. No.               | 158 mm                        | Tapping No of                      |
| 8 Grooves as per Drawing                                                       | Drg. No.               | 12x8x2 / 12x8x4               | Hole - 8                           |
| 9 Fitting Sizes on CNC Plate                                                   | Drg. No.               | OK                            | Both Side                          |
| 10 Drilling Area Surface Smoothness                                            |                        | OK                            |                                    |
| 11 Tapping Operator                                                            |                        | m/c Shop                      |                                    |
| 12 Tapping PCD                                                                 |                        | 454 mm                        |                                    |
| 13 Tapping Hole Diameter                                                       |                        | M-20 Chk by hand Tapping 18.5 |                                    |
| 14 Tapping On Second Side                                                      | Half pitch of 1st side | OK                            |                                    |
| 15 Tapping Hole Depth                                                          |                        | Drill depth 18.5              | Tapping Depth - 18.5               |
| 16 Perpendicularity of Tapped Hole                                             |                        | OK                            |                                    |
| 17 Visual Inspection Before Gun Drilling                                       |                        | OK                            |                                    |
| Inspected By (Sign) & Date                                                     |                        | Mahesh 04/04/25               |                                    |
| 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 for                        |
| 2 External Relief Dia                                                          | 3.5mm                  | out side (2-2)                | Inner                              |
| 3 External Relief Depth                                                        |                        | 13mm                          | 7mm                                |
| 4 Inspection Done Before Hardening By (Name)                                   |                        | Mahesh                        |                                    |
| 5 Material Sent For Hardening By (Name)                                        |                        | Lark furnace                  |                                    |
| 6 Material Sent For Hardening On Date                                          |                        | 04 04 25                      |                                    |
| Inspected By (Sign) & Date                                                     |                        | Mahesh 04/04/25               |                                    |

Reviewed by (Engineer-CNC)

Manager-QA