



# 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)

9509

| S.No. | Check Parameter                       | Specification          | Observations                        | Remarks            |
|-------|---------------------------------------|------------------------|-------------------------------------|--------------------|
| 1     | Work Order No.                        |                        | 14443                               | 36/45/55           |
| 2     | Machined By                           |                        | V. T. L. H/c Shop                   | Dy. 18.9.12        |
| 3     | Pallet Die No.                        |                        | 14131 (4.0) H/c                     | Rev. 00            |
| 4     | Die Category                          | Drg. No.               | H. Jumbo                            |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 710 H/c Step 00.092 H/c             | Step 10.12         |
| 6     | Inside Diameter                       | Drg. No.               | 600.12 H/c                          |                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 H/c                             |                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 12.5 x 8 x 7 H/c / 12.5 x 8 x 7 H/c |                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                                  |                    |
| 10    | Drilling Area Surface Smoothness      |                        | OK                                  |                    |
| 11    | Tapping Operator                      |                        | H/c Shop                            | Tapping H/c        |
| 12    | Tapping PCD                           |                        | 645 H/c                             | of 2-12.12         |
| 13    | Tapping Hole Diameter                 |                        | M20.2 Check by H20 Ball             | Both Side          |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                                  |                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 22.3 H/c                | Tapping Depth 20.5 |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                 |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                                  |                    |

Inspected By (Sign) & Date

Ravi 29/5/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 12.60 |
| 2 | External Relief Dia                        | 4.5 H/c / 5.0 H/c | 4.5 H/c | All Rows 2-19 H/c |    |  |  | Row 182       |
| 3 | External Relief Depth                      |                   | 5.0 H/c | All Rows 3-10 H/c |    |  |  |               |
| 4 | Inspection Done Before Hardening By (Name) |                   |         | Ravi              |    |  |  |               |
| 5 | Material Sent For Hardening By (Name)      |                   |         | Lark Engineering  |    |  |  |               |
| 6 | Material Sent For Hardening On Date        |                   | 29      | 3                 | 25 |  |  |               |

Inspected By (Sign) & Date

Ravi 29/5/25

Reviewed by (Engineer-CNC)

Manager-QA