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**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

**Inprocess Inspection (Pellet Dies)**

Rev. Date

31-07-2013

| No.                                                                            | Check Parameter                            | Specification          | Observations                            | Remarks                          |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-----------------------------------------|----------------------------------|
| 1                                                                              | Work Order No.                             |                        | 14534                                   | 40/40                            |
| 2                                                                              | Machined By                                |                        | V.T.L. H/a Shop                         | 2195                             |
| 3                                                                              | Pallet Die No.                             |                        | 13991(5.0) H/a                          |                                  |
| 4                                                                              | Die Category                               | Drg. No.               | Senior                                  |                                  |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 5mm H/a Step on 49.4mm                  | Step length 17.5                 |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 42.12 H/a                               |                                  |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 158 H/a                                 |                                  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 12x8x3 H/a   12x8x3 H/a                 |                                  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                                      |                                  |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                                      |                                  |
| 11                                                                             | Tapping Operator                           |                        | H/a Shop                                | Tapping H/a of Holes 8 Both Side |
| 12                                                                             | Tapping PCD                                |                        | 454 H/a                                 |                                  |
| 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 18.3mm Tapping Depth 16.6mm |                                  |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                                     |                                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                                      |                                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 28/3/25                            |                                  |
| 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 Bore                     |
| 2                                                                              | External Relief Dia                        | 5.5mm                  | Outside (2.2)                           | Inner                            |
| 3                                                                              | External Relief Depth                      |                        | 5mm                                     | Nil                              |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                    |                                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Porrace                            |                                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 28 3 25                                 |                                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 28/3/25                            |                                  |

Reviewed by (Engineer-CNC)

Manager-QA