



# 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.                             |                        | 14509                     | 28/40              |
| 2                                                                              | Machined By                                |                        | V.T.L. H/c Shop           | Dy. H/c Shop       |
| 3                                                                              | Pallet Die No.                             |                        | 13750 (3.5) H/c           |                    |
| 4                                                                              | Die Category                               | Drg. No.               | 5910                      |                    |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 500 H/c, Step OD. 491 H/c | Step length 17.5   |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 42.12 H/c                 |                    |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 182 H/c                   |                    |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 12x8x3 H/c   12x8x3 H/c   |                    |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                        |                    |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                        |                    |
| 11                                                                             | Tapping Operator                           |                        | H/c Shop                  |                    |
| 12                                                                             | Tapping PCD                                |                        | 454 H/c                   |                    |
| 13                                                                             | Tapping Hole Diameter                      |                        | H20, Check by H20 Bolt    |                    |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                        |                    |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth. 18.2 H/c     | Tapping Depth 18.5 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                       |                    |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                        |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 3/4/25               |                    |
| 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, Go               |                    |
| 2                                                                              | External Relief Dia                        | 4.0 H/c                | Outside 8.25              | Inner 12 H/c       |
| 3                                                                              | External Relief Depth                      |                        | 16 H/c                    |                    |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                      |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace              |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 3                         | 4 25               |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 3/4/25               |                    |

Reviewed by (Engineer-CNC)

Manager-QA