

6048



**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.                        |                        | 9980                                  | 35/50                            |
| 2     | Machined By                           |                        | N.T.L. N/C Shop                       | Drg No. BEEC-9980                |
| 3     | Pallet Die No.                        |                        | 10543 (2.5)mm                         | Rev 00                           |
| 4     | Die Category                          | Drg. No.               | Endrasside                            |                                  |
| 5     | Out Side Diameter                     | Drg. No.               | Ø20mm Step 002 Tapper                 | 12" Step length 18.5             |
| 6     | Inside Diameter                       | Drg. No.               | 52.12mm                               |                                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 22.2mm                                |                                  |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5mm / 13x8x5mm                   |                                  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                                    |                                  |
| 10    | Drilling Area Surface Smoothness      |                        | OK                                    |                                  |
| 11    | Tapping Operator                      |                        | N/C Shop                              | Tapping No of holes 12 Both Side |
| 12    | Tapping PCD                           |                        | 58.5mm                                |                                  |
| 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 20.4mm Tapping Depth 18.8 |                                  |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                   |                                  |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                                    |                                  |

Inspected By (Sign) & Date Ravi 11/9/23

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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    |               |   |       |  |  |  | Rep = 35 |
| 2 | External Relief Dia                        | 4.0mm | outside (2-3) |   | Inner |  |  |  |          |
| 3 | External Relief Depth                      |       | 18mm          |   | 15mm  |  |  |  |          |
| 4 | Inspection Done Before Hardening By (Name) |       | Ravi          |   |       |  |  |  |          |
| 5 | Material Sent For Hardening By (Name)      |       | Lark Furnace  |   |       |  |  |  |          |
| 6 | Material Sent For Hardening On Date        |       | 11            | 9 | 23    |  |  |  |          |

Inspected By (Sign) & Date Ravi 11/9/23

Reviewed by (Engineer-CNC) 11/9/23

Manager-QA