



# 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.                             |                        | 14478                        | 27/37/65                             |
| 2                                                                              | Machined By                                |                        | N.T.C. n/c Shop              | Qty 100 120 693                      |
| 3                                                                              | Pallet Die No.                             |                        | 14218 (3.8) n/c              | Rev 200                              |
| 4                                                                              | Die Category                               | Drg. No.               | Junbo                        |                                      |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 829.8 n/c Step 002 829.8 n/c | Tabber 40                            |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 700.14 n/c                   | Step length = 33 n/c                 |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 323.9 n/c                    |                                      |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 30x8x8.5 n/c   30x8x8.5 n/c  |                                      |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                           |                                      |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                           |                                      |
| 11                                                                             | Tapping Operator                           |                        | n/c Shop                     |                                      |
| 12                                                                             | Tapping PCD                                |                        | 780 n/c                      |                                      |
| 13                                                                             | Tapping Hole Diameter                      |                        | M22 Chack by M22 Bolt        | Tapping Hole of holes = 12 Both Side |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                           |                                      |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth = 36.4 n/c       | Tapping Depth 34                     |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                          |                                      |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                           |                                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 11/4/25                 |                                      |
| 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 - 2 Hole Closed           |                                      |
| Note : Mark the defective holes/Missed holes with the help of Permanent Marker |                                            |                        |                              |                                      |
| 1                                                                              | Counter Sinking Depth & Finish             | ok                     |                              | Counter 46                           |
| 2                                                                              | External Relief Dia                        | 4.3 n/c 4.8 n/c        | 4.3 n/c All Rows 28 n/c      |                                      |
| 3                                                                              | External Relief Depth                      |                        | 4.8 n/c All Rows 28 n/c      |                                      |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                         |                                      |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Rumarce                 |                                      |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 11 4 25                      |                                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 11/4/25                 |                                      |

Reviewed by (Engineer-CNC)

Manager-QA