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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

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

| S.No.                                                                          | Check Parameter                            | Specification          | Observations                              | Remarks                          |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-------------------------------------------|----------------------------------|
| 1                                                                              | Work Order No.                             |                        | 14386                                     | 36/40                            |
| 2                                                                              | Machined By                                |                        | V.T.L. H/c Shop                           | 91.9                             |
| 3                                                                              | Pallet Die No.                             |                        | 14779 (4.0) mm                            | 12.2                             |
| 4                                                                              | Die Category                               | Drg. No.               | Junior                                    |                                  |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 4.00 mm Step 0.2 3.95 mm Step length 14.5 |                                  |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 3.80 ± 0.2 mm                             |                                  |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 146 mm                                    |                                  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15.5 x 7 x 2 mm / 15.5 x 7 x 2 mm         |                                  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                                        |                                  |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                                        |                                  |
| 11                                                                             | Tapping Operator                           |                        | H/c Shop                                  |                                  |
| 12                                                                             | Tapping PCD                                |                        | 350 mm                                    |                                  |
| 13                                                                             | Tapping Hole Diameter                      |                        | M16 Check by H/c Ball                     | Tapping No. of holes 8 Both Side |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                                        |                                  |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.2 mm Tapping Depth 18.6    |                                  |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                                       |                                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                                        |                                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 5/4/25                               |                                  |
| 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 Sink 16                  |
| 2                                                                              | External Relief Dia                        | 6.5 mm                 | Outside 2-2                               | Inner 4 mm                       |
| 3                                                                              | External Relief Depth                      |                        | 8 mm                                      |                                  |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                      |                                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                              |                                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 5 4 25                                    |                                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 5/4/25                               |                                  |

Reviewed by (Engineer-CNC)

Manager-QA