



# 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

| S.No. | Check Parameter                       | Specification          | Observations                | Remarks                         |
|-------|---------------------------------------|------------------------|-----------------------------|---------------------------------|
| 1     | Work Order No.                        |                        | 14614                       | 60/60                           |
| 2     | Machined By                           |                        | V.T.L. n/c Shop             | Dr. H. 1.8.0.1050               |
| 3     | Pallet Die No.                        |                        | 14664 (8.0) m               | Rev. 00                         |
| 4     | Die Category                          | Drg. No.               | Jumbo (A2-1)                |                                 |
| 5     | Out Side Diameter                     | Drg. No.               | 75.0 mm, Step 0.2, 743.4 mm | Tapped 10                       |
| 6     | Inside Diameter                       | Drg. No.               | 63.012 mm                   | Step length 2.8 mm              |
| 7     | Width of Pellet Die                   | Drg. No.               | 265 mm                      |                                 |
| 8     | Grooves as per Drawing                | Drg. No.               | 15x8x5 mm / 15x8x5 mm       |                                 |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                          |                                 |
| 10    | Drilling Area Surface Smoothness      |                        | ok                          |                                 |
| 11    | Tapping Operator                      |                        | n/c Shop                    |                                 |
| 12    | Tapping PCD                           |                        | 685 mm                      |                                 |
| 13    | Tapping Hole Diameter                 |                        | M20, Check by M20 Ball      | Tapping H. of Hole 16 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 7/4/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 63 |
| 2 | External Relief Dia                        |    |  |  | No Relief   |  |  | Rev 22     |
| 3 | External Relief Depth                      |    |  |  |             |  |  |            |
| 4 | Inspection Done Before Hardening By (Name) |    |  |  | Ravi        |  |  |            |
| 5 | Material Sent For Hardening By (Name)      |    |  |  | Shri Keshav |  |  |            |
| 6 | Material Sent For Hardening On Date        |    |  |  | 7/4/25      |  |  |            |

### Inspected By (Sign) & Date

Ravi 7/4/25

Reviewed by (Engineer-CNC)

Manager-QA