



# 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.                        |                        | 14596                  | 35/55              |
| 2     | Machined By                           |                        | V.T.L. H/c Shop        | Dr H. 12.0.60      |
| 3     | Pallet Die No.                        |                        | 14136 (4.0) H/c        | Revised            |
| 4     | Die Category                          | Drg. No.               | H. Jumbo               |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 709.8 H/c              | Step 00-692.8 H/c  |
| 6     | Inside Diameter                       | Drg. No.               | 600.12 H/c             | Step length 12 H/c |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 H/c                |                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 12-1077.5 H/c          | 12-1077.5 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                           |                        | 640 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 20.4 H/c   | Tapping Depth 18.5 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                    |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                     |                    |

### Inspected By (Sign) & Date

Ravi: 10/4/25

|   |                                |        |                     |
|---|--------------------------------|--------|---------------------|
| 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 Colused |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

|   |                                            |         |        |  |        |  |  |  |  |
|---|--------------------------------------------|---------|--------|--|--------|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok      |        |  |        |  |  |  |  |
| 2 | External Relief Dia                        | 4.5 H/c | 23-31  |  | Inner  |  |  |  |  |
| 3 | External Relief Depth                      |         | 24 H/c |  | 20 H/c |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |         |        |  |        |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |         |        |  |        |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |         |        |  |        |  |  |  |  |

### Inspected By (Sign) & Date

Ravi: 10/4/25

Satish 10/4/25  
Reviewed by (Engineer-CNC)

Manager-QA