

# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

## Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9705

| S.No. | Check Parameter                       | Specification          | Observations                | Remarks            |
|-------|---------------------------------------|------------------------|-----------------------------|--------------------|
| 1     | Work Order No.                        |                        | 14752                       | 42/55              |
| 2     | Machined By                           |                        | V. T. L. n/a Shop           | Dy. No. 18.14994   |
| 3     | Pallet Die No.                        |                        | 13596(3.0) n/a              | Rev: 00            |
| 4     | Die Category                          | Drg. No.               | Extruder die                |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 329.9 n/a Step 00.611 A n/a | Step length 19.5   |
| 6     | Inside Diameter                       | Drg. No.               | 520.12 n/a                  |                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 n/a                     |                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 n/a / 13x8x5 n/a     |                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                          |                    |
| 10    | Drilling Area Surface Smoothness      |                        | ok                          |                    |
| 11    | Tapping Operator                      |                        | n/a Shop                    | Tapping Holes 12   |
| 12    | Tapping PCD                           |                        | 565 n/a                     | Both Side          |
| 13    | Tapping Hole Diameter                 |                        | n/a Check by H20 Bolt       |                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                          |                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.4 n/a        | Tapping Depth 18.5 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                         |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                          |                    |

Inspected By (Sign) & Date

Law: 24/4/25

|   |                                |        |                     |
|---|--------------------------------|--------|---------------------|
| 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 - 1 hole. Closed |

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

Counter Bo-

|   |                                            |         |               |   |        |  |  |  |  |
|---|--------------------------------------------|---------|---------------|---|--------|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok      |               |   |        |  |  |  |  |
| 2 | External Relief Dia                        | 3.5 n/a | Outside (3-3) |   | Inner  |  |  |  |  |
| 3 | External Relief Depth                      |         | 19 n/a        |   | 13 n/a |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |         |               |   |        |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |         |               |   |        |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |         | 24            | 4 | 25     |  |  |  |  |

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Reviewed by (Engineer-CNC)

Manager-QA