



# 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)

9816

| S.No. | Check Parameter                       | Specification          | Observations       | Remarks                 |
|-------|---------------------------------------|------------------------|--------------------|-------------------------|
| 1     | Work Order No.                        |                        | 14850 ✓            | 58/66 ✓                 |
| 2     | Machined By                           |                        | V. T. L. WLC Shop  | Drg No. 12.0.30         |
| 3     | Pallet Die No.                        |                        | 14990 (9.0) H      | Revised                 |
| 4     | Die Category                          | Drg. No.               | M. Jumbo           |                         |
| 5     | Out Side Diameter                     | Drg. No.               | 680.1 H            | Step 00. 693 H = Tapper |
| 6     | Inside Diameter                       | Drg. No.               | 546.12 H           | CBor - 548.1 H          |
| 7     | Width of Pellet Die                   | Drg. No.               | 195 H              | Step length 31 H        |
| 8     | Grooves as per Drawing                | Drg. No.               | 32 x 7 x 9.1 H     | End cut = 2.8 H         |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                 |                         |
| 10    | Drilling Area Surface Smoothness      |                        | OK                 |                         |
| 11    | Tapping Operator                      |                        | WLC Shop           |                         |
| 12    | Tapping PCD                           |                        | 619 H              |                         |
| 13    | Tapping Hole Diameter                 |                        | WLC                |                         |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                 |                         |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 33.4 H | Tapping Depth 31.6      |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                |                         |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                 |                         |

Inspected By (Sign) & Date

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|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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     |  |              |   |    |  |  |  |
| 2 | External Relief Dia                        | 10.0 H |  | All Rows     |   |    |  |  |  |
| 3 | External Relief Depth                      |        |  | 8 H          |   |    |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |        |  | Rev!         |   |    |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |        |  | Lark Purpore |   |    |  |  |  |
| 6 | Material Sent For Hardening On Date        |        |  | 8            | 5 | 25 |  |  |  |

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Reviewed by (Engineer-CNC)

Manager-QA