



# 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.                             |                        | 14958                                  | 55/66                 |
| 2                                                                              | Machined By                                |                        | V.T.L. n/c. Shop                       | 58/66                 |
| 3                                                                              | Pallet Die No.                             |                        | 14874 (10.0) mm                        | Dry H. 12.0. 330      |
| 4                                                                              | Die Category                               | Drg. No.               | N. Jumbo                               | Reco. 108             |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 680.1 mm Step 001 693 mm               | Tapp. 8"              |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 546.12 mm (Bore 548.12 mm)             | Step length 31 mm     |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 195 mm                                 | Under cut 2.8 mm      |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 32.7 x 9.1 mm   32.7 x 9.1 mm (4x2) mm | Face Side             |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                                     | Step 2 mm Deep        |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                                     | Both Side             |
| 11                                                                             | Tapping Operator                           |                        | n/c Shop                               | Tapping H. of holes 2 |
| 12                                                                             | Tapping PCD                                |                        | 619 mm                                 | Both Side             |
| 13                                                                             | Tapping Hole Diameter                      |                        | H16. Check by H16 Bolt                 |                       |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                                     |                       |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 33.4 mm                    | Tapping Depth 31.6 mm |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                                    |                       |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                                     |                       |
| Inspected By (Sign) & Date                                                     |                                            |                        | Sasi 21/5/25                           |                       |
| 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                     | Counters 60                            |                       |
| 2                                                                              | External Relief Dia                        | 11.0 mm                | 1st Pad                                | 2nd Pad               |
| 3                                                                              | External Relief Depth                      |                        | 10 mm                                  | 8 mm                  |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Sasi                                   |                       |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                           |                       |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 21                                     | 5 25                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Sasi 21/5/25                           |                       |

Reviewed by (Engineer-CNC)

Manager-QA