



# 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.                             |                        | 14938                                    | 29/42            |
| 2                                                                              | Machined By                                |                        | V.T.L. N/A Shop                          | Qty 4, 1.80.1543 |
| 3                                                                              | Pallet Die No.                             |                        | 14843 (2.8) 44                           | Rev. 1.00        |
| 4                                                                              | Die Category                               | Drg. No.               | 2.822 side                               |                  |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 614 44 Step 80-611.9 44 Step length 17.5 |                  |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 520.14 44                                |                  |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 222 44                                   |                  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x5 44 13x8x5 44                      |                  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                                       |                  |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                                       |                  |
| 11                                                                             | Tapping Operator                           |                        | N/A Shop                                 |                  |
| 12                                                                             | Tapping PCD                                |                        | 505 44                                   |                  |
| 13                                                                             | Tapping Hole Diameter                      |                        | 420.2 Check by N20 Bolt                  |                  |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                                       |                  |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.4 44 Tapping Depth 18.8   |                  |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                                      |                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                                       |                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 23/5/25                             |                  |
| 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                     |                                          |                  |
| 2                                                                              | External Relief Dia                        | 3.3 44                 | Outside (2-3)                            | Inner            |
| 3                                                                              | External Relief Depth                      |                        | 2.0 44                                   | 1.8 44           |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                     |                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Remove                              |                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 23                                       | 25               |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 23/5/25                             |                  |

9935

23/5/25

Manager-QA

Reviewed by (Engineer-CNC)