



# 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.                             |                        | 15014                         | 34/40                |
| 2                                                                              | Machined By                                |                        | N.T.L. H/c Shop               | Drg. No. 1.2.0.04    |
| 3                                                                              | Pallet Die No.                             |                        | 13763 (4.0) H/c               | Rev. 01              |
| 4                                                                              | Die Category                               | Drg. No.               | 3810                          |                      |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 499.9 H/c, Step 001 490.9 H/c | Step length 7 H/c    |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 420.14 H/c                    |                      |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 182 H/c                       |                      |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 10x10x5 H/c   10x10x5 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                                |                        | 455 H/c                       |                      |
| 13                                                                             | Tapping Hole Diameter                      |                        | 0214" 2 Check by 0214" Ball   |                      |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                            |                      |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 19.4 H/c          | Tapping Depth 012 2  |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                           |                      |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                            |                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 22/5/25                  |                      |
| 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                     |                               | Counter Sink Rev. 25 |
| 2                                                                              | External Relief Dia                        | 4.5 H/c                | Outside (2-25)                | Inner                |
| 3                                                                              | External Relief Depth                      |                        | 10 H/c                        | Gun                  |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                          |                      |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Permac                   |                      |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 22                            | 5                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 22/5/25                  |                      |

Reviewed by (Engineer-CNC)

Manager-QA