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# 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 Paramotor                            | Spociflcation          | Observations                             | Remarks                          |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|------------------------------------------|----------------------------------|
| 1                                                                              | Work Order No.                             |                        | 149AG                                    | 50/55                            |
| 2                                                                              | Machined By                                |                        | V.T.L. H/O Shop                          | Drg. No. 19.0.9-3                |
| 3                                                                              | Pallet Die No.                             |                        | 14430 (8.0) H/O                          | 200.00                           |
| 4                                                                              | Die Category                               | Drg. No.               | Senior                                   |                                  |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 530.4 H/O, Step 02, 499.4 H/O            | Tapper 12                        |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 420.12 H/O                               | Step length 18 H/O               |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 158.3 H/O                                |                                  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 12x8x3 H/O / 12x9.6x3 H/O                |                                  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                                       |                                  |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                                       |                                  |
| 11                                                                             | Tapping Operator                           |                        | H/O Shop                                 | Tapping H/O of Hole 8 Right Side |
| 12                                                                             | Tapping PCD                                |                        | 454 H/O                                  |                                  |
| 13                                                                             | Tapping Hole Diameter                      |                        | H/O, Check by H/O Bolt                   |                                  |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                                       |                                  |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 19 H/O, Tapping Depth 17 H/O |                                  |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                                      |                                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                                       |                                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 24/5/25                             |                                  |
| 1                                                                              | As per programme no.                       |                        |                                          |                                  |
| 2                                                                              | Gun Drilling Work Completed On             |                        |                                          |                                  |
| 3                                                                              | Hole Finish In Gun Drilling                | Marked                 | OK                                       |                                  |
| 4                                                                              | Defective Holes (If Any)                   |                        | N/A                                      |                                  |
| Note : Mark the defective holes/Missed holes with the help of Permanent Marker |                                            |                        |                                          | Counter G.I.                     |
| 1                                                                              | Counter Sinking Depth & Finish             |                        | OK                                       | Ravi 12                          |
| 2                                                                              | External Relief Dia                        |                        | 8.5 H/O, Outside (2-2)                   | Inner                            |
| 3                                                                              | External Relief Depth                      |                        | 13 H/O                                   | 5 H/O                            |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                     |                                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                             |                                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 24 5 25                                  |                                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 24/5/25                             |                                  |

Reviewed by (Engineer-CNC)

Manager-QA