



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9981

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.                             |                        | 15069                             | 50/50                             |
| 2                                                                              | Machined By                                |                        | V.T.L. H/C Shop                   | Dr. H. L. R. 14/8/05              |
| 3                                                                              | Pallet Die No.                             |                        | 14606 (G.O) H/C                   | Rev. 03                           |
| 4                                                                              | Die Category                               | Drg. No.               | H. J. R. D.                       |                                   |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 700.9 mm                          | Step OD = Taper = 12°             |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 600.14 mm                         | Step length = 17.4                |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 265.6 mm                          |                                   |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15.3 x 8 x 7 mm / 15.3 x 8 x 7 mm |                                   |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                                |                                   |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                                |                                   |
| 11                                                                             | Tapping Operator                           |                        | H/C Shop                          | Tapping No. of Holes 16 Both Side |
| 12                                                                             | Tapping PCD                                |                        | 640 mm                            |                                   |
| 13                                                                             | Tapping Hole Diameter                      |                        | H202 Check by H20 Bolt            |                                   |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                                |                                   |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth = 20.6 mm             | Tapping Depth = 18.7              |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                               |                                   |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                                |                                   |
| Inspected By (Sign) & Date                                                     |                                            |                        | Rev. 29/5/25                      |                                   |
| 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 = 60                      |
| 2                                                                              | External Relief Dia                        | 6.5 mm                 | Outside (3-2)                     | Rev. 28                           |
| 3                                                                              | External Relief Depth                      |                        | 6 mm                              | Inner                             |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        |                                   | Nil                               |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        |                                   | Rev.                              |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 29                                | 5                                 |
| Inspected By (Sign) & Date                                                     |                                            |                        | Rev. 29/5/25                      |                                   |

29/5/25

Reviewed by (Engineer-CNC)

Manager-QA

Manager-QA

Rev