



# 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)

10002

| S.No. | Check Parameter                       | Specification          | Observations                            | Remarks                         |
|-------|---------------------------------------|------------------------|-----------------------------------------|---------------------------------|
| 1     | Work Order No.                        |                        |                                         |                                 |
| 2     | Machined By                           |                        | 15091                                   | 45/45                           |
| 3     | Pallet Die No.                        |                        | V.T.L. H/c Shop                         | By H. 18.2.1152                 |
| 4     | Die Category                          | Drg. No.               | 14513 (2.8) H/c                         | Rev. 00                         |
| 5     | Out Side Diameter                     | Drg. No.               | Senior                                  |                                 |
| 6     | Inside Diameter                       | Drg. No.               | 510 H/c Step 001 491 H/c                | Step length 13-5                |
| 7     | Width of Pellet Die                   | Drg. No.               | 420.12 H/c                              |                                 |
| 8     | Grooves as per Drawing                | Drg. No.               | 158 H/c                                 |                                 |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 12x8x3 H/c / 12x8x3 H/c                 |                                 |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                      |                                 |
| 11    | Tapping Operator                      |                        | H/c Shop                                |                                 |
| 12    | Tapping PCD                           |                        | 454 H/c                                 |                                 |
| 13    | Tapping Hole Diameter                 |                        | 03 1/4" 2 Check by 03 1/4" Bolt         | Tapping H. of Holes 8 Rate Side |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                      |                                 |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 18.3 H/c Tapping Depth 18.6 |                                 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                     |                                 |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                      |                                 |

### Inspected By (Sign) & Date

Raw: 31/5/25

|   |                                |        |                    |
|---|--------------------------------|--------|--------------------|
| 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 - 1 Hole Closed |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter, 20

|   |                                            |         |              |  |       |  |  |  |  |
|---|--------------------------------------------|---------|--------------|--|-------|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok      |              |  |       |  |  |  |  |
| 2 | External Relief Dia                        | 3.1 H/c | 20 Side 2.25 |  | Inner |  |  |  |  |
| 3 | External Relief Depth                      |         | 6 H/c        |  | Mill  |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |         |              |  |       |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |         |              |  |       |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |         |              |  |       |  |  |  |  |

### Inspected By (Sign) & Date

Raw: 31/5/25

Reviewed by (Engineer-CNC)

Manager-QA