



# Lark Engineering Company (India) Pvt. Ltd.

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

10089

|           |              |
|-----------|--------------|
| 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.                             |                        | 15232                    | 52/55                  |
| 2                                                                              | Machined By                                |                        | V.T.L. M/C Shop          | Dy. 18.0.539           |
| 3                                                                              | Pallet Die No.                             |                        | 13898(4.0) No.           | Rev. 00                |
| 4                                                                              | Die Category                               | Drg. No.               | 58870                    |                        |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 629.8mm, Step on 623.8mm | Tapping 12             |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 520.14mm                 | Step length 2mm        |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 186mm                    |                        |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x3mm / 13x8x3mm      |                        |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                       |                        |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                       |                        |
| 11                                                                             | Tapping Operator                           |                        | M/C Shop                 | Tapping M. of Holes 12 |
| 12                                                                             | Tapping PCD                                |                        | 565mm                    | Back Side              |
| 13                                                                             | Tapping Hole Diameter                      |                        | 4mm, Check by H2 Ball    |                        |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                       |                        |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.5mm       | Tapping Depth 18.0     |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                      |                        |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                       |                        |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 16/6/25             |                        |
| 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                        | 4.5mm                  | 23-25                    | Inner 3mm              |
| 3                                                                              | External Relief Depth                      |                        | 11mm                     |                        |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                     |                        |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Porroce             |                        |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 16/6/25                  |                        |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 16/6/25             |                        |

Reviewed by (Engineer-CNC)

Manager-QA