



# 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)

10123

| S.No.                                                                          | Check Parameter                            | Specification          | Observations                        | Remarks        |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-------------------------------------|----------------|
| 1                                                                              | Work Order No.                             |                        | 15237 ✓                             | 36/50 ✓        |
| 2                                                                              | Machined By                                |                        | V. T. C. H/C Shop                   | Dy H. 68.0978  |
| 3                                                                              | Pallet Die No.                             |                        | 14856 (2.8) H                       | Revised        |
| 4                                                                              | Die Category                               | Drg. No.               | Extra side                          |                |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 62mm, Step 00. Tappers 12°          |                |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 52.14mm                             | Step long 18.5 |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 222mm                               |                |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x5mm / 12x8x5mm                 |                |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                                  |                |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                                  |                |
| 11                                                                             | Tapping Operator                           |                        | H/C Shop                            |                |
| 12                                                                             | Tapping PCD                                |                        | 565mm                               |                |
| 13                                                                             | Tapping Hole Diameter                      |                        | H20. Check by H20 Bolt              |                |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                                  |                |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20mm Tapping Depth 18.6 |                |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                                 |                |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                                  |                |
| Inspected By (Sign) & Date                                                     |                                            |                        | Soni 19/6/25                        |                |
| 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             |                        |                                     | Counter 60°    |
| 2                                                                              | External Relief Dia                        | 3.2mm                  | 3.3mm                               | Inner          |
| 3                                                                              | External Relief Depth                      |                        | 19mm                                | 14mm           |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Soni                                |                |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Rurnace                        |                |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 19 6 25                             |                |
| Inspected By (Sign) & Date                                                     |                                            |                        | Soni 19/6/25                        |                |

Reviewed by (Engineer-CNC)

Manager-QA