



# 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)

10161

| S.No.                                                                          | Check Parameter                            | Specification          | Observations               | Remarks            |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|----------------------------|--------------------|
| 1                                                                              | Work Order No.                             |                        | 15236 ✓                    | 25/45              |
| 2                                                                              | Machined By                                |                        | V.T.L. n/c Shop            | ① Dry n/c 12-12-13 |
| 3                                                                              | Pallet Die No.                             |                        | 14725 (3.0) n/c            | Rev = 00           |
| 4                                                                              | Die Category                               | Drg. No.               | SS810                      |                    |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 610 n/c - Step 002 623.144 | Tapping 12         |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 520.14 n/c                 | Step length 20     |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 186 n/c                    | Under cut 6.5 n/c  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x3 n/c / 173x8x3 n/c   |                    |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                         |                    |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                         |                    |
| 11                                                                             | Tapping Operator                           |                        | n/c Shop                   | Tapping n/c        |
| 12                                                                             | Tapping PCD                                |                        | 565 n/c                    | 2 holes 12         |
| 13                                                                             | Tapping Hole Diameter                      |                        | M20 - Check by M20 R-14    | Both Side          |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                         |                    |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.4 n/c       | Tapping Depth 18.6 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                        |                    |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                         |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Sasi 26/6/25               |                    |
| 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 6          |
| 2                                                                              | External Relief Dia                        |                        | 13.5 n/c                   | 8010-80            |
| 3                                                                              | External Relief Depth                      |                        | 23 n/c                     |                    |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Sasi                       |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace               |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 26                         | 6 25               |
| Inspected By (Sign) & Date                                                     |                                            |                        | Sasi 26/6/25               |                    |

Reviewed by (Engineer-CNC)

Manager-QA