



# 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)

| S.No.                                                                          | Check Parameter                            | Specification          | Observations        | Remarks          |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|---------------------|------------------|
| 1                                                                              | Work Order No.                             |                        |                     |                  |
| 2                                                                              | Machined By                                |                        | 15251               | B-165            |
| 3                                                                              | Pallet Die No.                             |                        | V.T.L. H/c Shop     | Drg. H/c Shop    |
| 4                                                                              | Die Category                               | Drg. No.               | 15314 (3.5) H/c     | See 200          |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 790mm               | Step 00 - 792mm  |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 660.14mm            | Step length 20   |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 324mm               | Undercut 1mm     |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 21.5 x 8 x 8 mm     | 21.5 x 8 x 8 mm  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                  |                  |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                  |                  |
| 11                                                                             | Tapping Operator                           |                        | H/c Shop            | Tapping H/c      |
| 12                                                                             | Tapping PCD                                |                        | 725mm               | of Holes - 2     |
| 13                                                                             | Tapping Hole Diameter                      |                        | H20                 | Check by H20 B.1 |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                  | Both Side        |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 31.4mm  | Tapping Depth 20 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                 |                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                  |                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 28/6/25        | 28/6/25          |
| 1                                                                              | As per programme no.                       |                        |                     | 2.1mm width      |
| 2                                                                              | Gun Drilling Work Completed On             |                        |                     | B H/c Shop       |
| 3                                                                              | Hole Finish In Gun Drilling                | Marked                 | OK                  | Both Side        |
| 4                                                                              | Defective Holes (If Any)                   |                        | No - 2 Hole Colused |                  |
| 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                        | 4.0mm                  | Outside 3-35        | Inner            |
| 3                                                                              | External Relief Depth                      |                        | 12mm                | 5mm              |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                |                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Purnace        |                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 28                  | 6 25             |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 28/6/25        |                  |

Reviewed by (Engineer-CNC)

Manager-QA