



# Lark Engineering Company (India) Pvt. Ltd.

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

10229

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                           |                        | 15406                         | 19/66                                |
| 3     | Pallet Die No.                        |                        | N.T.L. H/c Shop               | Dr. No. 12.0.0-9                     |
| 4     | Die Category                          | Drg. No.               | 15167 (B.O.)                  | Rev. 03                              |
| 5     | Out Side Diameter                     | Drg. No.               | N.T.L. H/c Shop               | Grade 475                            |
| 6     | Inside Diameter                       | Drg. No.               | 6.80.7 H/c Shop               | Step 00. 893 H/c Shop                |
| 7     | Width of Pellet Die                   | Drg. No.               | 546.12 H/c Shop (Ber - 548.4) | Step length 3 H/c Shop               |
| 8     | Grooves as per Drawing                | Drg. No.               | 195 H/c Shop                  | Under cut = 0.5 H/c Shop             |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 32.7 x 9.2 H/c Shop           | 32.7 x 9.2 H/c Shop (4 x 8) H/c Shop |
| 10    | Drilling Area Surface Smoothness      |                        | OK                            | Face Side                            |
| 11    | Tapping Operator                      |                        | OK                            | Step 8 H/c Shop                      |
| 12    | Tapping PCD                           |                        | H/c Shop                      | Back Side                            |
| 13    | Tapping Hole Diameter                 |                        | 619 H/c Shop                  | Tapping H/c Shop                     |
| 14    | Tapping On Second Side                | Half pitch of 1st side | H/c Shop                      | of holes                             |
| 15    | Tapping Hole Depth                    |                        | OK                            | Back Side                            |
| 16    | Perpendicularity of Tapped Hole       |                        | Drill Depth 33.5 H/c Shop     | Tapping Depth 31.5                   |
| 17    | Visual Inspection Before Gun Drilling |                        | Yes                           |                                      |
|       |                                       |                        | OK                            |                                      |

### Inspected By (Sign) & Date

Rev. 8/7/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 Sink |
| 2 | External Relief Dia                        | 7.5 H/c Shop |  |  |  |  |  |  |  | Rev. 12      |
| 3 | External Relief Depth                      |              |  |  |  |  |  |  |  |              |
| 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

Rev. 8/7/25

Reviewed by (Engineer-CNC)

Manager-QA