



# Lark Engineering Company (India) Pvt. Ltd.

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

10270

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 ✓                        | 19/06                |
| 3     | Pallet Die No.                        |                        | V.7.6 H/c Shop                 | Dy. 1.18.06.09       |
| 4     | Die Category                          | Drg. No.               | 15169 (B.O.) H/c               | Rev. 03              |
| 5     | Out Side Diameter                     | Drg. No.               | H. Jumbo                       | 4+3                  |
| 6     | Inside Diameter                       | Drg. No.               | 680.7 H/c, Step 02, 693 H/c    | Tabber 2.8           |
| 7     | Width of Pellet Die                   | Drg. No.               | 546.12 H/c, (B.O. - 548.4 H/c) | Step length 3 H/c    |
| 8     | Grooves as per Drawing                | Drg. No.               | 195 H/c                        | Under cut = 2.5      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 32.7 x 92 H/c / 32.7 x 9.2 H/c | (4 x 8) H/c          |
| 10    | Drilling Area Surface Smoothness      |                        | OK                             | Face Side            |
| 11    | Tapping Operator                      |                        | OK                             | 2 H/c Deep           |
| 12    | Tapping PCD                           |                        | H/c Shop                       | Both Side            |
| 13    | Tapping Hole Diameter                 |                        | 619 H/c                        | Tapping H/c          |
| 14    | Tapping On Second Side                | Half pitch of 1st side | H/c, Check by H/c Bolt         | of Holes = 2         |
| 15    | Tapping Hole Depth                    |                        | OK                             | Both Side            |
| 16    | Perpendicularity of Tapped Hole       |                        | Drill Depth = 33.4 H/c         | Tapping Depth = 31.6 |
| 17    | Visual Inspection Before Gun Drilling |                        | Yes                            |                      |
|       |                                       |                        | OK                             |                      |

Inspected By (Sign) & Date

Ravi 11/7/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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

Counter 2 Bo

|   |                                            |         |                    |              |   |    |  |  |  |         |
|---|--------------------------------------------|---------|--------------------|--------------|---|----|--|--|--|---------|
| 1 | Counter Sinking Depth & Finish             | OK      |                    |              |   |    |  |  |  | Ravi 12 |
| 2 | External Relief Dia                        | 7.5 H/c | <del>7.5 H/c</del> | All Rows     |   |    |  |  |  |         |
| 3 | External Relief Depth                      |         |                    | 47 H/c       |   |    |  |  |  |         |
| 4 | Inspection Done Before Hardening By (Name) |         |                    | Ravi         |   |    |  |  |  |         |
| 5 | Material Sent For Hardening By (Name)      |         |                    | Lark Purrace |   |    |  |  |  |         |
| 6 | Material Sent For Hardening On Date        |         |                    | 11           | 7 | 25 |  |  |  |         |

Inspected By (Sign) & Date

Ravi 11/7/25

Reviewed by (Engineer-CNC)

Manager-QA