



# 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)

1025

| S.No.                                                                          | Check Parameter                            | Specification          | Observations           | Remarks            |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|------------------------|--------------------|
| 1                                                                              | Work Order No.                             |                        | 15518                  | 44/50              |
| 2                                                                              | Machined By                                |                        | V. T. L. H/O Shop      | Drg No. 1202450    |
| 3                                                                              | Pallet Die No.                             |                        | 15222(4.0)H            | Rev. 00            |
| 4                                                                              | Die Category                               | Drg. No.               | J&W                    |                    |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 730mm Step 00. 743.5mm | Tapping 10         |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 630.14mm               | Step length 23mm   |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 290mm                  | Cut off 6-75       |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15x8x5mm / 15x8x5mm    | Core Side Step     |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                     | 0.8mm Deep         |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                     | Both Side          |
| 11                                                                             | Tapping Operator                           |                        | H/O Shop               | Tapping 10         |
| 12                                                                             | Tapping PCD                                |                        | 885mm                  | of Hole 16         |
| 13                                                                             | Tapping Hole Diameter                      |                        | 420. Check by H20.8    | Both Side          |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                     |                    |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.4mm     | Tapping Depth 18.5 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                    |                    |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                     |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 12/7/25           | Ravi Ramesh        |
| 1                                                                              | As per programme no.                       |                        |                        | Drg No. 12.0.450   |
| 2                                                                              | Gun Drilling Work Completed On             |                        |                        | Rev. 00            |
| 3                                                                              | Hole Finish In Gun Drilling                | Marked                 | OK                     |                    |
| 4                                                                              | Defective Holes (If Any)                   |                        | No - 14.10 Colours     |                    |
| 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                        | 4.5mm                  | Outside 83-85          | Inner 6mm          |
| 3                                                                              | External Relief Depth                      |                        | 14mm                   |                    |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                   |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Leah Ramesh            |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 12 7 25                |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 12/7/25           |                    |

Reviewed by (Engineer-CNC)

Manager-QA