



# Lark Engineering Company (India) Pvt. Ltd.

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

10336

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.                        |                        | 15464 ✓                           | 57/66                  |
| 2     | Machined By                           |                        | V-7.1. n/c Shop                   | Dr. No. 19.2.32        |
| 3     | Pallet Die No.                        |                        | 15552(8.0) ✓                      | Dr. No. 19.2.32        |
| 4     | Die Category                          | Drg. No.               | M. Jom bo                         | Dr. No. 19.2.32        |
| 5     | Out Side Diameter                     | Drg. No.               | 680.2 mm Step 00. 693 mm          | Tapping 18°            |
| 6     | Inside Diameter                       | Drg. No.               | 546.14 mm (Bor 2548.2) ✓          | Step length 23 mm      |
| 7     | Width of Pellet Die                   | Drg. No.               | 195 mm ✓                          | Under cut 2.7 mm       |
| 8     | Grooves as per Drawing                | Drg. No.               | 324749.1 mm / 324749.1 mm (4x2) ✓ | Face Side              |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                | 2 mm Deep              |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                | Botu Side              |
| 11    | Tapping Operator                      |                        | n/c Shop                          | Tapping No. of holes 2 |
| 12    | Tapping PCD                           |                        | 619 mm ✓                          | Botu Side              |
| 13    | Tapping Hole Diameter                 |                        | N/A. Check by HIR 14              | Tapping Depth 91.6     |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                |                        |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 33.6 mm               |                        |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                               |                        |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                |                        |

Inspected By (Sign) & Date

Ravi 23/7/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 30

|   |                                            |        |    |              |    |  |  |          |
|---|--------------------------------------------|--------|----|--------------|----|--|--|----------|
| 1 | Counter Sinking Depth & Finish             | ok     |    |              |    |  |  | Row = 10 |
| 2 | External Relief Dia                        | 9.0 mm |    | All Rows     |    |  |  |          |
| 3 | External Relief Depth                      | ✓      |    | 9 mm ✓       |    |  |  |          |
| 4 | Inspection Done Before Hardening By (Name) |        |    | Ravi         |    |  |  |          |
| 5 | Material Sent For Hardening By (Name)      |        |    | Lark Furnace |    |  |  |          |
| 6 | Material Sent For Hardening On Date        |        | 23 | 7            | 25 |  |  |          |

Inspected By (Sign) & Date

Ravi 23/7/25

Satya 23/7/25

Reviewed by (Engineer-CNC)

Manager-QA