



# 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.                             |                        | 15421                               | 30/50              |
| 2                                                                              | Machined By                                |                        | N. T. L. m/c Shop                   | Dy No. 120.450     |
| 3                                                                              | Pallet Die No.                             |                        | 15475(3.0) m/c                      | Rev. 02            |
| 4                                                                              | Die Category                               | Drg. No.               | 760                                 |                    |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 730 m/c, Step 00. 744 m/c           | Tapping 10         |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 630.14 m/c                          | Step length 23.3   |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 290.6 m/c                           | Under cut = 7 m/c  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15.3 x 8 x 5 m/c / 15.3 x 8 x 5 m/c | Face Side Step     |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                                  | 0.8 m/c Deep       |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                                  | Both Side          |
| 11                                                                             | Tapping Operator                           |                        | m/c Shop                            | Tapping No. 7      |
| 12                                                                             | Tapping PCD                                |                        | 685 m/c                             | of holes 16        |
| 13                                                                             | Tapping Hole Diameter                      |                        | M20 Check by M20 Bolt               | Both Side          |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                                  |                    |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.5 m/c                | Tapping Depth 18.0 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                                 |                    |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                                  |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi: 25/7/25                       |                    |
| 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 69         |
| 2                                                                              | External Relief Dia                        | 3.5 m/c                | 22-3) Outer Side                    | Rev. 58            |
| 3                                                                              | External Relief Depth                      |                        | 23 m/c                              | Inner 20 m/c       |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                        |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 25 7 25                             |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi: 25/7/25                       |                    |

Satish 25/7/25

Reviewed by (Engineer-CNC)

Manager-QA