



# Lark Engineering Company (India) Pvt. Ltd.

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

10387

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                           |                        | 15664                   | 40/40                    |
| 3     | Pallet Die No.                        |                        | V.7.L. n/c Shop         | Day Hrs Lark             |
| 4     | Die Category                          | Drg. No.               | 14899 (4.0) n/c         |                          |
| 5     | Out Side Diameter                     | Drg. No.               | Senior                  |                          |
| 6     | Inside Diameter                       | Drg. No.               | 500 n/c                 | Step 00. 491 n/c         |
| 7     | Width of Pellet Die                   | Drg. No.               | 420.14 n/c              | Step length 17.5         |
| 8     | Grooves as per Drawing                | Drg. No.               | 158 n/c                 |                          |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 12x8x3 n/c / 12x8x3 n/c |                          |
| 10    | Drilling Area Surface Smoothness      |                        | ok                      |                          |
| 11    | Tapping Operator                      |                        | ok                      |                          |
| 12    | Tapping PCD                           |                        | n/c Shop                |                          |
| 13    | Tapping Hole Diameter                 |                        | 454 n/c                 | Tapping Holes of holes B |
| 14    | Tapping On Second Side                | Half pitch of 1st side | n/c 2 Check by n/c Bolt | Back Side                |
| 15    | Tapping Hole Depth                    |                        | ok                      |                          |
| 16    | Perpendicularity of Tapped Hole       |                        | Drill Depth 18.8 n/c    | Tapping Depth 18.7       |
| 17    | Visual Inspection Before Gun Drilling |                        | yes                     |                          |
|       |                                       |                        | ok                      |                          |

### Inspected By (Sign) & Date

Ravi 30/7/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 60 |
| 2 | External Relief Dia                        | 4.5 n/c | Outside 2.25 |   | Inner |  |  |  | Rev. 20    |
| 3 | External Relief Depth                      |         | 4 n/c        |   | Nil   |  |  |  |            |
| 4 | Inspection Done Before Hardening By (Name) |         |              |   |       |  |  |  |            |
| 5 | Material Sent For Hardening By (Name)      |         |              |   |       |  |  |  |            |
| 6 | Material Sent For Hardening On Date        |         |              |   |       |  |  |  |            |
|   |                                            |         | 30           | 7 | 25    |  |  |  |            |

### Inspected By (Sign) & Date

Ravi 30/7/25

Reviewed by (Engineer-CNC)

Manager-QA