10424

# 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. | | 15862 | 35140 |
| 2 | Machined By | | V.T.L M/c Shop | Dy No. lark 8195 9370 |
| 3 | Pallet Die No. | | 15087 (5.0) MM | |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 499.9 MM, Step OD. 490.8 MM | Step length 18.5 |
| 6 | Inside Diameter | Drg. No. | 420.14 MM | |
| 7 | Width of Pellet Die | Drg. No. | 158 MM | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 MM / 12x8x3 MM | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | M/c Shop | Tapping No of holes: 8 Both Side |
| 12 | Tapping PCD | | 454 MM | |
| 13 | Tapping Hole Diameter | | M20, Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth. 18.8 MM | Tapping Depth. 18.8 MM |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | Inspected By (Sign) & Date | | Ravi 5/8/25 | |
| 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. Ro: Ravi 17 |
| 2 | External Relief Dia | 5.5 MM | outside (2.2) | | Inner | | | |
| 3 | External Relief Depth | | 10 MM | | 5 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 | | 5 | 8 | 25 | | | |
| | Inspected By (Sign) & Date | | Ravi 5/8/25 | | | | | |

Sat 5/8/25

Reviewed by (Engineer-CNC)

Manager-QA