



# Lark Engineering Company (India) Pvt. Ltd.

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

10508

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.                        |                        | 15755                  | 45/50             |
| 2     | Machined By                           |                        | V. T. L. H/c Shop      | Dray due 1.8.0999 |
| 3     | Pallet Die No.                        |                        | 15423(4.0) H/c         | Rev - 00          |
| 4     | Die Category                          | Drg. No.               | Extrusion Die          |                   |
| 5     | Out Side Diameter                     | Drg. No.               | 619.9 H/c              | Step 00           |
| 6     | Inside Diameter                       | Drg. No.               | 520.14 H/c             | Taper 12.4°       |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 H/c                | Step length 18.5  |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 H/c             |                   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                     |                   |
| 10    | Drilling Area Surface Smoothness      |                        | ok                     |                   |
| 11    | Tapping Operator                      |                        | H/c Shop               |                   |
| 12    | Tapping PCD                           |                        | 565 H/c                |                   |
| 13    | Tapping Hole Diameter                 |                        | H202 Check by H20 Bolt |                   |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                     |                   |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.5 H/c   |                   |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                    |                   |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                     |                   |

### Inspected By (Sign) & Date

Ravi 21/8/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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      |               |   |       |  |  |  |  |
| 2 | External Relief Dia                        | 4.5 H/c | Outside (3-3) |   | Inner |  |  |  |  |
| 3 | External Relief Depth                      |         | 13 H/c        |   | 5 H/c |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |         |               |   |       |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |         |               |   |       |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |         | 21            | 8 | 25    |  |  |  |  |

### Inspected By (Sign) & Date

Ravi 21/8/25

Reviewed by (Engineer-CNC)

Manager-QA