



# 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.                        |                        | 15789                  | 37/50              |
| 2     | Machined By                           |                        | V. T. L. n/c Shop      | Qty 1.200          |
| 3     | Pallet Die No.                        |                        | 15428(3.5)             | Rev 2.00           |
| 4     | Die Category                          | Drg. No.               | Outside                |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 619.9mm                | Step 00.1          |
| 6     | Inside Diameter                       | Drg. No.               | 520.14mm               | Tabber 12.5        |
| 7     | Width of Pellet Die                   | Drg. No.               | 222mm                  | Step length 18.5   |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5mm               |                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                     |                    |
| 10    | Drilling Area Surface Smoothness      |                        | ok                     |                    |
| 11    | Tapping Operator                      |                        | n/c Shop               |                    |
| 12    | Tapping PCD                           |                        | 565mm                  |                    |
| 13    | Tapping Hole Diameter                 |                        | H200 Check by H20 Bolt |                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                     |                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.5mm     | Tabbing Depth 18.4 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                    |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                     |                    |

### Inspected By (Sign) & Date

Raj 25/8/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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                        | 4.0mm | Outside 23-37 |   | Inner |  |  |  |  |
| 3 | External Relief Depth                      |       | 17mm          |   | 13mm  |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |       |               |   |       |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |       |               |   |       |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |       | 25            | 8 | 25    |  |  |  |  |

### Inspected By (Sign) & Date

Raj 25/8/25

Reviewed by (Engineer-CNC)

Manager-QA