



# 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.                        |                        | 15806                 | 35/40                          |
| 2     | Machined By                           |                        | V. T. L. w/o Shop     | By H. L. 10.5                  |
| 3     | Pallet Die No.                        |                        | 15280(4.0) w/o        |                                |
| 4     | Die Category                          | Drg. No.               | Senior                |                                |
| 5     | Out Side Diameter                     | Drg. No.               | 499.9 w/o             | Step on 490.9 w/o              |
| 6     | Inside Diameter                       | Drg. No.               | 420.14 w/o            | Step length 17.5               |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 w/o               |                                |
| 8     | Grooves as per Drawing                | Drg. No.               | 12-8-3 w/o            | 12-8-3 w/o                     |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                    |                                |
| 10    | Drilling Area Surface Smoothness      |                        | ok                    |                                |
| 11    | Tapping Operator                      |                        | w/o Shop              |                                |
| 12    | Tapping PCD                           |                        | 454 w/o               |                                |
| 13    | Tapping Hole Diameter                 |                        | H20 Check by H20 Ball | Tapping H20 of H20.8 Both Side |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                    |                                |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 18.4 w/o  | Tapping Depth 16.4             |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                   |                                |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                    |                                |

### Inspected By (Sign) & Date

Ravi 29/8/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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      |              |   |              |  |  | Count on 80 |
| 2                          | External Relief Dia                        | 4.5 w/o | Outside 2.25 |   | Inner        |  |  | Rep 2.25    |
| 3                          | External Relief Depth                      |         | 9 w/o        |   | 5 w/o        |  |  |             |
| 4                          | Inspection Done Before Hardening By (Name) |         |              |   | Ravi         |  |  |             |
| 5                          | Material Sent For Hardening By (Name)      |         |              |   | Lark Porrace |  |  |             |
| 6                          | Material Sent For Hardening On Date        |         | 29           | 8 | 25           |  |  |             |
| Inspected By (Sign) & Date |                                            |         | Ravi 29/8/25 |   |              |  |  |             |

Reviewed by (Engineer-CNC)  
Sats 29/8/25

Manager-QA