



# 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.                        |                        | 15945 ✓                    | 50/50 ✓             |
| 2     | Machined By                           |                        | V.T.I. H/c Shop            | 50/50 ✓             |
| 3     | Pallet Die No.                        |                        | 15007 (6.0) ✓              | 50/50 ✓             |
| 4     | Die Category                          | Drg. No.               | Extra wide                 |                     |
| 5     | Out Side Diameter                     | Drg. No.               | 619.9 mm, Step on 611.7 mm | Step length 17.5    |
| 6     | Inside Diameter                       | Drg. No.               | 520.14 mm                  |                     |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 mm                     |                     |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 mm / 13x8x5 mm      |                     |
| 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 mm                     |                     |
| 13    | Tapping Hole Diameter                 |                        | H20, Check by H20 Ball     |                     |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                         |                     |
| 15    | Tapping Hole Depth                    |                        | Drill Depth: 20.5 mm       | Tapping Depth: 18.5 |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                        |                     |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                         |                     |

Inspected By (Sign) & Date

Ravi 29/7/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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                        | 6.5 mm | Outside (3-3) |   | Inner |  |  |  |  | Rev: 20      |
| 3 | External Relief Depth                      |        | 5 mm          |   | Mill  |  |  |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |        |               |   |       |  |  |  |  |              |
| 5 | Material Sent For Hardening By (Name)      |        |               |   |       |  |  |  |  |              |
| 6 | Material Sent For Hardening On Date        |        | 2             | 9 | 25    |  |  |  |  |              |

Inspected By (Sign) & Date

Ravi 29/7/25

Reviewed by (Engineer-CNC)

Manager-QA