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# 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.                             |                        | 15845 ✓               | 39/50                |
| 2                                                                              | Machined By                                |                        | V.T.I M/c Shop        | Dray No = 450        |
| 3                                                                              | Pallet Die No.                             |                        | 15766 (3.0) m         | Rev: 02              |
| 4                                                                              | Die Category                               | Drg. No.               | J & D                 |                      |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 730 mm ✓              | Step oD = 743.9 mm   |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 630.14 mm             | Tapper 10°           |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 290.6 mm ✓            | Step length 93 mm    |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15.3 x 8 x 5 mm       | 15.3 x 8 x 5 mm      |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                    | Face Side            |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                    | Both Side            |
| 11                                                                             | Tapping Operator                           |                        | M/c Shop              | Tapping No           |
| 12                                                                             | Tapping PCD                                |                        | 685 mm ✓              | of Holes = 16        |
| 13                                                                             | Tapping Hole Diameter                      |                        | 42 = Check by 420 R/L | Both Side            |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                    |                      |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill depth = 20.4 mm | Tapping Depth 118 mm |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                   |                      |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                    |                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 13/9/25          |                      |
| 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 - 1 Hole Closed    |                      |
| 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                        |                        | 3.5 mm                | Row = 52             |
| 3                                                                              | External Relief Depth                      |                        | 17 mm                 |                      |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                  |                      |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Purrae           |                      |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 13 9 25               |                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 13/9/25          |                      |

Reviewed by (Engineer-CNC)

Manager-QA