



# 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.                        |                        | 16081                                      | 33/66                        |
| 2     | Machined By                           |                        | V.T.L M/c Shop                             | Dry No. LSD-600              |
| 3     | Pallet Die No.                        |                        | 16259 (6.0) mm                             | (Rev-03)                     |
| 4     | Die Category                          | Drg. No.               | M. Jumbo                                   | throat 4x5                   |
| 5     | Out Side Diameter                     | Drg. No.               | 680.7 mm                                   | Step 05 = 693 mm Tapper = 8° |
| 6     | Inside Diameter                       | Drg. No.               | 546.14 mm (Bar, 548.4)                     | Step length = 31 mm          |
| 7     | Width of Pellet Die                   | Drg. No.               | 195 mm                                     | Under Cord = 2.5 mm          |
| 8     | Grooves as per Drawing                | Drg. No.               | 32 x 7 x 9.2 mm / 32 x 7 x 9.2 mm (4x8) mm |                              |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                                         | Face Side Step               |
| 10    | Drilling Area Surface Smoothness      |                        | OK                                         | 2 mm Deep Bore               |
| 11    | Tapping Operator                      |                        | M/c Shop                                   | Tapping No                   |
| 12    | Tapping PCD                           |                        | 619 mm                                     | of holes = 2                 |
| 13    | Tapping Hole Diameter                 |                        | H16, Check by H16 Ball                     | Both Side                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                                         |                              |
| 15    | Tapping Hole Depth                    |                        | Drill depth = 33.5 mm                      | Tapping depth = 31.5         |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                        |                              |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                                         |                              |

### Inspected By (Sign) & Date

Ravi 15/9/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

|   |                                            |        |         |              |   |    |  |               |
|---|--------------------------------------------|--------|---------|--------------|---|----|--|---------------|
| 1 | Counter Sinking Depth & Finish             | OK     | outside | Inner        |   |    |  | Counter - 30° |
| 2 | External Relief Dia                        | 7.5 mm |         | All Rows     |   |    |  | Row - 12      |
| 3 | External Relief Depth                      |        |         | 33 mm        |   |    |  |               |
| 4 | Inspection Done Before Hardening By (Name) |        |         | Ravi         |   |    |  |               |
| 5 | Material Sent For Hardening By (Name)      |        |         | Lark Furnace |   |    |  |               |
| 6 | Material Sent For Hardening On Date        |        |         | 15           | 9 | 25 |  |               |

### Inspected By (Sign) & Date

Ravi 15-9-25

Reviewed by (Engineer-CNC)

Manager-QA