



# 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.                             |                        | 16027 to 16104          | 60/60            |
| 2                                                                              | Machined By                                |                        | V.T.L. H/c Shop         | Dr. H. 12.0.36   |
| 3                                                                              | Pallet Die No.                             |                        | 15348 (4.0) H/c         | Revised          |
| 4                                                                              | Die Category                               | Drg. No.               | J&D                     |                  |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 75.0 H/c                | Step 0.8 mm      |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 63.0.12 H/c             | Step length 28.3 |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 29.0.6 H/c              |                  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15.3 x 8 x 5 H/c        | 15.3 x 8.5 H/c   |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                      | Face Side        |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                      | Step 0.8 mm      |
| 11                                                                             | Tapping Operator                           |                        | H/c Shop                | Deep Boh Side    |
| 12                                                                             | Tapping PCD                                |                        | 68.5 H/c                | Tapping H/c      |
| 13                                                                             | Tapping Hole Diameter                      |                        | H20 - Check by H20 Bolt | of holes. 16     |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                      | Boh Side         |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth = 20.6 H/c  | Tapping Depth 18 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                     |                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                      |                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 15/9/25            | Tapping Naga     |
| 1                                                                              | As per programme no.                       |                        |                         | Quality 2nd      |
| 2                                                                              | Gun Drilling Work Completed On             |                        |                         | Approved By      |
| 3                                                                              | Hole Finish In Gun Drilling                | Marked                 | OK                      | Sachin Sir       |
| 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                        | -                      | No - Relief             | Ravi 43          |
| 3                                                                              | External Relief Depth                      |                        |                         |                  |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                    |                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Purchase           |                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 15/9/25                 |                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 15/9/25            |                  |

Reviewed by (Engineer-CNC)

Manager-QA