10671

# 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. | | 16035 | 43/50 |
| 2 | Machined By | | V.T.I M/c Shop | Dry No = Lark 5.812 |
| 3 | Pallet Die No. | | 15693 (4.5) mm | Row = 00 |
| 4 | Die Category | Drg. No. | Carbide | |
| 5 | Out Side Diameter | Drg. No. | Ø19.9 mm, Step OD. Ø11.9 mm | Step length 17.9 |
| 6 | Inside Diameter | Drg. No. | 50.14 mm | |
| 7 | Width of Pellet Die | Drg. No. | 22 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 | | M/c Shop | Tapping No of Holes = 12 Both Side |
| 12 | Tapping PCD | | 565 mm | |
| 13 | Tapping Hole Diameter | | M = 20 = Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill depth = 20.5 mm | Tapping depth 18.9 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |
| | Inspected By (Sign) & Date | | Ravi 18/9/25 | |
| 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 | | | | | | Counter = 60° Row = 29 |
| 2 | External Relief Dia | 5.0 mm | Outside (3-3) | | Inner | | | |
| 3 | External Relief Depth | | 12 mm | | 7 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 | | | 18 | 9 | 25 | | |
| | Inspected By (Sign) & Date | | Ravi 17/9/25 | | | | | |

17/9/25

Reviewed by (Engineer-CNC)

Manager-QA