



# 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)

10679

| S.No.                                                                          | Check Parameter                            | Specification          | Observations            | Remarks                  |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-------------------------|--------------------------|
| 1                                                                              | Work Order No.                             |                        | 16054 ✓                 | 32/40                    |
| 2                                                                              | Machined By                                |                        | V.T.L M/c Shop          | Dry No. 180.942          |
| 3                                                                              | Pallet Die No.                             |                        | 15699 (3.0) H           | Rev 1.00                 |
| 4                                                                              | Die Category                               | Drg. No.               | Extra wide              |                          |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 600 H                   | Step OD = 821.4 H        |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 520.14 H                | Tapper = 12              |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 222 H                   | Step length = 21.4       |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x5 H / 13x8x5 H     | Under cut = 10.7 H       |
| 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 |
| 12                                                                             | Tapping PCD                                |                        | 565 H                   | Both Side                |
| 13                                                                             | Tapping Hole Diameter                      |                        | H202 Check by H202 Bolt |                          |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                      |                          |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill depth = 20.4 H    | Tapping depth = 8.4      |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                     |                          |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                      |                          |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 19/9/25            |                          |
| 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 80               |
| 2                                                                              | External Relief Dia                        | 3.3 H                  | All Rows                | Row 2 88                 |
| 3                                                                              | External Relief Depth                      |                        | 8 H                     |                          |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                    |                          |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark - Furnace          |                          |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 19 9 25                 |                          |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 19/9/25            |                          |

Satish 19/9/25

Reviewed by (Engineer-CNC)

Manager-QA