



# 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.                             |                        | 15782                           | 31/36/69             |
| 2                                                                              | Machined By                                |                        | V.T.I M/c Shop                  | 31/36/69             |
| 3                                                                              | Pallet Die No.                             |                        | 15359 (6.0) mm                  | Dry No. 1.20833      |
| 4                                                                              | Die Category                               | Drg. No.               | Jumbo                           | Rev. No.             |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 838 mm                          | Step 2.5             |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 698.14 mm (Box = 700.14) mm     | Step length = 28.5   |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 240 mm                          | Undercut = 1.9 mm    |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 29 x 10 x 9 mm / 29 x 10 x 9 mm | (6-8) mm             |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                              | Face Side Step       |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                              | 1 mm Deep Both side  |
| 11                                                                             | Tapping Operator                           |                        | M/c Shop                        | Tapping No           |
| 12                                                                             | Tapping PCD                                |                        | 76.5 mm                         | of Hole = 2          |
| 13                                                                             | Tapping Hole Diameter                      |                        | 1416 - Check by M16 Bolt        | Both side            |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                              |                      |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill depth = 32.4 mm           | Tapping depth = 30.3 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                             |                      |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                              |                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 20/9/25                    |                      |
| 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                     | 1st Pad 7.1 mm                  | Counter = 60         |
| 2                                                                              | External Relief Dia                        | 7.0 mm 7.5 mm          | 7.0 mm = 48 mm                  | Row = 18             |
| 3                                                                              | External Relief Depth                      |                        | 7.5 mm = 43 mm                  |                      |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi 20/9                       |                      |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                    |                      |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 20 9 25                         |                      |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 20/9/25                    |                      |

Reviewed by (Engineer-CNC)

Manager-QA