



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10726

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.                        |                        | 16050                       | 45/55                |
| 2     | Machined By                           |                        | V.T.L. M/c Shop             | Dry No = 18.2.410    |
| 3     | Pallet Die No.                        |                        | 15322 (8.0) M               | Rev. 01              |
| 4     | Die Category                          | Drg. No.               | SSS-10                      |                      |
| 5     | Out Side Diameter                     | Drg. No.               | 630 M                       | Step OD = 623.8 M    |
| 6     | Inside Diameter                       | Drg. No.               | 520.14 M                    | Taper = 12°          |
| 7     | Width of Pellet Die                   | Drg. No.               | 186 M                       | Step length 18 M     |
| 8     | Grooves as per Drawing                | Drg. No.               | 13 x 8 x 3 M / 13 x 8 x 9 M |                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                          |                      |
| 10    | Drilling Area Surface Smoothness      |                        | OK                          |                      |
| 11    | Tapping Operator                      |                        | M/c Shop                    | Tapping No           |
| 12    | Tapping PCD                           |                        | 565 M                       | of Hole = 12         |
| 13    | Tapping Hole Diameter                 |                        | M20, Check by M20 R.L.      | Both side            |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                          |                      |
| 15    | Tapping Hole Depth                    |                        | Drill depth = 20.4 M        | Tapping depth = 18.4 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                         |                      |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                          |                      |

### Inspected By (Sign) & Date

Ravi 23/9/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 280 |
| 2 | External Relief Dia                        | 8.5 M | Outside (3-3) |    | Inner        |    |  | 20.14       |
| 3 | External Relief Depth                      |       | 18 M          |    | 10 M         |    |  |             |
| 4 | Inspection Done Before Hardening By (Name) |       |               |    | Ravi         |    |  |             |
| 5 | Material Sent For Hardening By (Name)      |       |               |    | Lark Furnace |    |  |             |
| 6 | Material Sent For Hardening On Date        |       |               | 23 | 9            | 25 |  |             |

### Inspected By (Sign) & Date

Ravi 23-9-25

Reviewed by (Engineer-CNC)

Manager-QA