



# 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.                        |                        | 16138                 | 36/65                     |
| 2     | Machined By                           |                        | J.T.L M/c Shop        | Dray No. 12.0.390         |
| 3     | Pallet Die No.                        |                        | 16265 (10.0) M        | Rev. 1.08                 |
| 4     | Die Category                          | Drg. No.               | M. Jumbo              | 473                       |
| 5     | Out Side Diameter                     | Drg. No.               | 680.1 M               | Step OD = 693 M Tapper 8° |
| 6     | Inside Diameter                       | Drg. No.               | 546.12 M (Bor. 548.2) | Step length = 31 M        |
| 7     | Width of Pellet Die                   | Drg. No.               | 195 M                 | End cut = 2.8 M           |
| 8     | Grooves as per Drawing                | Drg. No.               | 32 x 7 x 9.1 M        | (4 x 8) M                 |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                    | Face Side Step            |
| 10    | Drilling Area Surface Smoothness      |                        | OK                    | Both Side                 |
| 11    | Tapping Operator                      |                        | M/c Shop              | Tapping No                |
| 12    | Tapping PCD                           |                        | 619 M                 | of Holes = 2              |
| 13    | Tapping Hole Diameter                 |                        | M16                   | Both Side                 |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                    |                           |
| 15    | Tapping Hole Depth                    |                        | Drill depth = 33.4 M  | Tapping depth = 31.6      |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                   |                           |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                    |                           |

### Inspected By (Sign) & Date

Ravi 29/9/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 260° |
| 2 | External Relief Dia                        | —  | — | No           | Relief |    |  | Row = 8      |
| 3 | External Relief Depth                      |    |   |              |        |    |  |              |
| 4 | Inspection Done Before Hardening By (Name) |    |   | Ravi         |        |    |  |              |
| 5 | Material Sent For Hardening By (Name)      |    |   | Lark Furnace |        |    |  |              |
| 6 | Material Sent For Hardening On Date        |    |   | 29           | 9      | 25 |  |              |

### Inspected By (Sign) & Date

Ravi 29/9/25

Reviewed by (Engineer-CNC)

Manager-QA