



# 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)

10805

| S.No. | Check Parameter                       | Specification          | Observations           | Remarks              |
|-------|---------------------------------------|------------------------|------------------------|----------------------|
| 1     | Work Order No.                        |                        | 16013                  | 44/50                |
| 2     | Machined By                           |                        | VTL - M/c Shop         |                      |
| 3     | Pallet Die No.                        |                        | 15843 (4.0) mm         | Drg No. 150 415 Regd |
| 4     | Die Category                          | Drg. No.               | Senior                 |                      |
| 5     | Out Side Diameter                     | Drg. No.               | 520 mm                 | Step on 499 mm       |
| 6     | Inside Diameter                       | Drg. No.               | 420 mm                 | Step length 20 mm    |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 mm                 |                      |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x8x3 mm              |                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                     |                      |
| 10    | Drilling Area Surface Smoothness      |                        | OK                     | Tapping No of Hole 8 |
| 11    | Tapping Operator                      |                        | m/c Shop               | Both side            |
| 12    | Tapping PCD                           |                        | 454 mm                 |                      |
| 13    | Tapping Hole Diameter                 |                        | M 20 Check by M20 Ball |                      |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                     |                      |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.5       | Tapping Depth 18.5   |
| 16    | Perpendicularity of Tapped Hole       |                        | Xed                    |                      |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                     |                      |

### Inspected By (Sign) & Date

Mahesh 6/10/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 |
| 2 | External Relief Dia                        | 4.5 mm | outer 2-2 |  | Inner @      |    |    | Row 20     |
| 3 | External Relief Depth                      |        | 4.5 mm    |  | 6.4 mm       |    |    |            |
| 4 | Inspection Done Before Hardening By (Name) |        |           |  | Mahesh       |    |    |            |
| 5 | Material Sent For Hardening By (Name)      |        |           |  | Lark furnace |    |    |            |
| 6 | Material Sent For Hardening On Date        |        |           |  | 6            | 10 | 25 |            |

### Inspected By (Sign) & Date

Mahesh 6/10/25

Reviewed by (Engineer-CNC)

Manager-QA