

# 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)

10824

| S.No. | Check Parameter                       | Specification          | Observations                         | Remarks           |
|-------|---------------------------------------|------------------------|--------------------------------------|-------------------|
| 1     | Work Order No.                        |                        | 16095                                | 50/55             |
| 2     | Machined By                           |                        | VTL-M/C Shop                         | Order No 453 Room |
| 3     | Pallet Die No.                        |                        | 15790 (4.0) mm                       |                   |
| 4     | Die Category                          | Drg. No.               | Jumbo & W                            |                   |
| 5     | Out Side Diameter                     | Drg. No.               | 740 mm Step 02 744                   |                   |
| 6     | Inside Diameter                       | Drg. No.               | 630 mm                               | Step Length 235   |
| 7     | Width of Pellet Die                   | Drg. No.               | 290.6 mm                             |                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 15.3 x 8 x 5 mm                      | Tapping Hole      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                                   | Hole 16           |
| 10    | Drilling Area Surface Smoothness      |                        | OK                                   |                   |
| 11    | Tapping Operator                      |                        | M/C Shop                             | Both Side         |
| 12    | Tapping PCD                           |                        | 685 mm                               |                   |
| 13    | Tapping Hole Diameter                 |                        | M20 check by M2 Bolt                 |                   |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                                   |                   |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.5 mm Tapping Depth 45 |                   |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                  |                   |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                                   |                   |

### Inspected By (Sign) & Date

Maheesh 8/10/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 1 | As per programme no.           |        |    |
| 2 | Gun Drilling Work Completed On |        |    |
| 3 | Hole Finish In Gun Drilling    | Marked | OK |
| 4 | Defective Holes (If Any)       |        | NA |

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 (2.3)   |    | Inner |  | Row 43      |
| 3 | External Relief Depth                      |        | 13.3 mm       |    | 5.5   |  |             |
| 4 | Inspection Done Before Hardening By (Name) |        | Maheesh       |    |       |  |             |
| 5 | Material Sent For Hardening By (Name)      |        | Lark Furnence |    |       |  |             |
| 6 | Material Sent For Hardening On Date        |        | 8             | 10 | 25    |  |             |

### Inspected By (Sign) & Date

Maheesh

Reviewed by (Engineer-CNC)

Manager-QA