



# 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)

10874

| S.No.                                                                          | Check Parameter                            | Specification          | Observations                                 | Remarks            |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|----------------------------------------------|--------------------|
| 1                                                                              | Work Order No.                             |                        | 16292 ✓                                      | 30/66              |
| 2                                                                              | Machined By                                |                        | V. T. L. n/c Shop                            | Drg. No. 12.0.39   |
| 3                                                                              | Pallet Die No.                             |                        | 1347-2 (G.O) n/c                             | Rev. 08            |
| 4                                                                              | Die Category                               | Drg. No.               | H. Jambha                                    |                    |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 680.144, Step 00. 692.944                    | Tapping 8          |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 546.144 (Base 548.2)                         | Step length 31     |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 195 mm                                       | Green cent. 2.8    |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 32 x 7 x 9.1 mm   32 x 7 x 9.1 mm (4 x 8) mm |                    |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                                           |                    |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                                           | Face Side Step     |
| 11                                                                             | Tapping Operator                           |                        | n/c Shop                                     | Back Side          |
| 12                                                                             | Tapping PCD                                |                        | 619 mm                                       | Body Side          |
| 13                                                                             | Tapping Hole Diameter                      |                        | M16, Check by M16 Ball                       | Tapping H. of      |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                                           | Holes 2            |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 33.4 mm                          | Tapping Depth 31.3 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                                          |                    |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                                           |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 14/10/25                                |                    |
| 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 30         |
| 2                                                                              | External Relief Dia                        | 7.0 mm                 | All Rows                                     | Row 12             |
| 3                                                                              | External Relief Depth                      |                        | 36 mm                                        |                    |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                         |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Quarnace                                |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 14 10 25                                     |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 14/10/25                                |                    |

Reviewed by (Engineer-CNC)

Manager-QA