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**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.                        |                        | 11266                   | 45/50                                |
| 2     | Machined By                           |                        | V.T.L n/c Shop          | Drg No. LFC 13760                    |
| 3     | Pallet Die No.                        |                        | 11697 (6.0) n/c         | Rev 2.00                             |
| 4     | Die Category                          | Drg. No.               | Senior                  |                                      |
| 5     | Out Side Diameter                     | Drg. No.               | 520.1 n/c               | Step OD = 491.1 n/c                  |
| 6     | Inside Diameter                       | Drg. No.               | 420.12 n/c              | Step length = 7.4                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 n/c                 |                                      |
| 8     | Grooves as per Drawing                | Drg. No.               | 12+8+3 n/c              |                                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                      |                                      |
| 10    | Drilling Area Surface Smoothness      |                        | ok                      |                                      |
| 11    | Tapping Operator                      |                        | n/c Shop                | Tapping No of Holes = 8<br>Both side |
| 12    | Tapping PCD                           |                        | 454 n/c                 |                                      |
| 13    | Tapping Hole Diameter                 |                        | M20 = Check by M20 Bolt |                                      |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                      |                                      |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 19.8 n/c  | Tapping Depth = 17.4 n/c             |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                     |                                      |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                      |                                      |

Inspected By (Sign) & Date Ravi 18/8/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 Counter = 60

|   |  |         |               |   |       |  |  |  |              |
|---|--|---------|---------------|---|-------|--|--|--|--------------|
| 1 | Counter Sinking Depth & Finish             | ok      |               |   |       |  |  |  |              |
| 2 | External Relief Dia                        | 6.5 n/c | outside (2-2) |   | Inner |  |  |  |              |
| 3 | External Relief Depth                      |         | 11 n/c        |   | 5 n/c |  |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |         |               |   |       |  |  |  | Ravi         |
| 5 | Material Sent For Hardening By (Name)      |         |               |   |       |  |  |  | Lark Furnace |
| 6 | Material Sent For Hardening On Date        |         | 18            | 2 | 24    |  |  |  |              |

Inspected By (Sign) & Date Ravi 18/8/24

Reviewed by (Engineer-CNC) S. K. Singh 12/8/24

Manager-QA