



# 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.                        |                        | 11252   | 45/45                       |
| 2     | Machined By                           |                        | V.T.L. H/c Shop                               | Drg. No. 1.3.0.541          |
| 3     | Pallet Die No.                        |                        | 10671 (8.0) H/c                               | Rev 2.0                     |
| 4     | Die Category                          | Drg. No.               | Junior  |                             |
| 5     | Out Side Diameter                     | Drg. No.               | 410 H/c Step 00, 395 H/c                      | Step length 14.4            |
| 6     | Inside Diameter                       | Drg. No.               | 320.12 H/c                                    |                             |
| 7     | Width of Pellet Die                   | Drg. No.               | 142 H/c                                       |                             |
| 8     | Grooves as per Drawing                | Drg. No.               | 15.5 x 7 x 2 H/c                              |                             |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok  |                             |
| 10    | Drilling Area Surface Smoothness      |                        | ok  |                             |
| 11    | Tapping Operator                      |                        | H/c Shop                                      | Tapping of Hole 8 Beta Side |
| 12    | Tapping PCD                           |                        | 355 H/c                                       |                             |
| 13    | Tapping Hole Diameter                 |                        | M16 = Check by M16 Bolt                       |                             |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok  |                             |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 21.4 H/c Tapping Depth = 19 H/c |                             |
| 16    | Perpendicularity of Tapped Hole       |                        | yes   |                             |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                             |

Inspected By (Sign) & Date

Ravi 13/2/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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

|   |  |         |               |       |    |  |  |  |              |
|---|--|---------|---------------|-------|----|--|--|--|--------------|
| 1 | Counter Sinking Depth & Finish             | ok      |               |       |    |  |  |  | Counter 60   |
| 2 | External Relief Dia                        | 8.5 H/c | Outside (2-2) | Inner |    |  |  |  |              |
| 3 | External Relief Depth                      |         | 8 H/c         | Nil   |    |  |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |         |               |       |    |  |  |  | Ravi         |
| 5 | Material Sent For Hardening By (Name)      |         |               |       |    |  |  |  | Lark Furnace |
| 6 | Material Sent For Hardening On Date        |         | 13            | 2     | 24 |  |  |  |              |

Inspected By (Sign) & Date

Ravi 12/2/24

Reviewed by (Engineer-CNC)

Manager-QA