



# 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.                             |                        | 11870                                 | 40/60                                |
| 2  | Machined By                                |                        | V. T. L. n/c Shop                     | Dry 11.1.13.0.584                    |
| 3  | Pallet Die No.                             |                        | 12302 (6.0) n/c                       | Rev. 2.01                            |
| 4  | Die Category                               | Drg. No.               | Jumbo                                 |                                      |
| 5  | Out Side Diameter                          | Drg. No.               | 780 n/c, Step 60, 798 n/c             | Tabber 6"                            |
| 6  | Inside Diameter                            | Drg. No.               | 660.12 n/c                            | Step length 25.5                     |
| 7  | Width of Pellet Die                        | Drg. No.               | 324 n/c                               | Under cut 9 n/c                      |
| 8  | Grooves as per Drawing                     | Drg. No.               | 21.5 x 8 x 10 n/c   21.5 x 8 x 10 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 12 Both Side     |
| 12   | Tapping PCD                                |                        | 725 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 Probe, 31 n/c                   | Tapping Depth 28.8                   |
| 16   | Perpendicularity of Tapped Hole            |                        | yes                                   |                                      |
| 17   | Visual Inspection Before Gun Drilling      |                        | ok                                    |                                      |
| Inspected By (Sign) & Date   |  |                        | Ravi 11/5/24                          | 2 Slot                               |
| 1  | As per programme no.                       |                        | _____                                 | 32.1 n/c width 8 n/c Depth Both Side |
| 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                        | 6.5 n/c                | Outside (2.3)                         | Rev. 34                              |
| 3  | External Relief Depth                      |                        | 26 n/c                                | Inner 20 n/c                         |
| 4  | Inspection Done Before Hardening By (Name) |                        | Ravi                                  |                                      |
| 5  | Material Sent For Hardening By (Name)      |                        | Lark Forware                          |                                      |
| 6  | Material Sent For Hardening On Date        |                        | 11 5 24                               |                                      |
| Inspected By (Sign) & Date   |  |                        | Ravi 11/5/24                          |                                      |

Reviewed by (Engineer-CNC)

Manager-QA