



# 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.                        |                        | 14094                 | 30/50                      |
| 2     | Machined By                           |                        | V. T. L. H/c Shop     | Dy. No. 13.2.450           |
| 3     | Pallet Die No.                        |                        | 13163 (3.0) H/c       | Rev. No.                   |
| 4     | Die Category                          | Drg. No.               | 740                   |                            |
| 5     | Out Side Diameter                     | Drg. No.               | 730 H/c               | Step on 743.5 H/c          |
| 6     | Inside Diameter                       | Drg. No.               | 630.12 H/c            | Tabber 10                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 290 H/c               | Step length 28 H/c         |
| 8     | Grooves as per Drawing                | Drg. No.               | 15x8x5 H/c            | Undercut 6.8 H/c           |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                    |                            |
| 10    | Drilling Area Surface Smoothness      |                        | OK                    |                            |
| 11    | Tapping Operator                      |                        | H/c Shop              |                            |
| 12    | Tapping PCD                           |                        | 68.5 H/c              |                            |
| 13    | Tapping Hole Diameter                 |                        | H202 Check by M2 Bolt |                            |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                    |                            |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.3 H/c  | Tabbing Depth 1.2 13.8 H/c |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                   |                            |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                    |                            |

### Inspected By (Sign) & Date

Ravi 25/2/25

|   |                                |        |                  |  |
|---|--------------------------------|--------|------------------|--|
| 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 - Hole Closed |  |

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                        | 3.5 H/c | Outside (3.3) |   | Inner  |  |  | Low 52       |
| 3 | External Relief Depth                      |         | 23 H/c        |   | 20 H/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        |         | 25            | 2 | 25     |  |  |              |

### Inspected By (Sign) & Date

Ravi 25/2/25

Reviewed By (Engineer-CNC)

Manager-QA