10235

# 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. | | 15398 | 50/50 |
| 2 | Machined By | | V.T.L H/a Shop | Dy No. 120.761 |
| 3 | Pallet Die No. | | 1560d (5.0) | Rev 00 |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 520 mm, Stock OD. 498.8 | Tapper 12° |
| 6 | Inside Diameter | Drg. No. | 480.14 mm | Stock length 118 mm |
| 7 | Width of Pellet Die | Drg. No. | 158 mm | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 mm / 12x8x3 mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | Ok | |
| 10 | Drilling Area Surface Smoothness | | Ok | |
| 11 | Tapping Operator | | H/a Shop | [Tapping No. of holes 8 Both side] |
| 12 | Tapping PCD | | 454 mm | |
| 13 | Tapping Hole Diameter | | M20, Crack by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | Ok | |
| 15 | Tapping Hole Depth | | Drill Depth 18.5 mm | Tapping Depth 16.5 |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | Ok | |
| | Inspected By (Sign) & Date | | Ravi 8/7/25 | |
| 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

Counter Go: Rev = 12

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | |
| 2 | External Relief Dia | 5.5 mm | outside (2-2) | | Inner | | | |
| 3 | External Relief Depth | | 5 mm | | Mill | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Forge | | | | | |
| 6 | Material Sent For Hardening On Date | | 8 | 7 | 25 | | | |
| | Inspected By (Sign) & Date | | Ravi 8/7/25 | | | | | |

Satyam 8/7/25

Reviewed by (Engineer-CNC)

Manager-QA