



# 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.		12903	42/45
2	Machined By		V.T.L M/c Shop	Dry No. Lec/14949
3	Pallet Die No.		13204 (3.5) mm	Row (00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 mm	Step od 491mm
6	Inside Diameter	Drg. No.	420.12 mm	Step length 115mm
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	Tapping Mark Hall - 2 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M.20 check by M.20 Bolt	Tapping depth. 16.5mm
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 24/09/24

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 - 1 Hole close

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	(4.0) mm	outside		Inner			Row - 22
3	External Relief Depth		(2.2)		3mm			
4	Inspection Done Before Hardening By (Name)		10mm		Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		24	09	24			

### Inspected By (Sign) & Date

Ravi 24/09/24

Reviewed by (Engineer-CNC)

Manager-QA