



# 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.		12934	52/55
2	Machined By		N.T.L. N/C Shop	Drg No. 1-2-C2/14924
3	Pallet Die No.		12649(3.5) N/C	Rev: 100
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630mm Step 0.2 612.4mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565mm	Tapping No. of holes, 12 Both Side
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 Depth 20.4mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 23/9/24

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	4.0mm	Outside (3-3)	Inner			Row = 35
3	External Relief Depth		10mm	3mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		23	9	24		

### Inspected By (Sign) & Date

Ravi 23/9/24

Reviewed by (Engineer-CNC)  
S. S. 23/9/24

Manager-QA