



# 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.		12985 ✓	39/50
2	Machined By		V.T.C. N/C Shop	8752 Dy. Lark 3870
3	Pallet Die No.		10525 (3.5) ✓	
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	620mm Step OD, 618mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12mm / 520.14mm (A)	
7	Width of Pellet Die	Drg. No.	186.1mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565mm	Tapping dia 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 21.4mm	Tapping Depth 19mm
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° Ravi 27
2	External Relief Dia	4.0mm	Outside (2-3)		Inner			
3	External Relief Depth		18mm		11mm			
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)

Manager-QA