



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		12971 ✓	30/40/50/852
3	Pallet Die No.		V.T.L. n/c Shop	Original Lark 3310 ✓
4	Die Category	Drg. No.	11868 (4.0) n/c	
5	Out Side Diameter	Drg. No.	58810	
6	Inside Diameter	Drg. No.	620 n/c Step 0.0, 612 n/c	Step length 19.4 ✓
7	Width of Pellet Die	Drg. No.	520.12 n/c	
8	Grooves as per Drawing	Drg. No.	186 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c ✓	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: 20.4 n/c	Tapping Depth: 18.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Raoi 11/10/24

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 = 80° low 1.25 ✓
2	External Relief Dia	4.5 n/c / 5.0 n/c ✓	4.5 n/c All Rows	5.0 n/c All Rows			
3	External Relief Depth		20 n/c	10 n/c			
4	Inspection Done Before Hardening By (Name)						Raoi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		1	10	24		

### Inspected By (Sign) & Date

Raoi 11/10/24

Reviewed by (Engineer-CNC)

Manager-QA