



# 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.		12994 ✓	40/55 ✓
2	Machined By		V.T.L. H/c Shop	Dry Hole 1.30-355
3	Pallet Die No.		13364 (4.0) mm ✓	Rev 200 ✓
4	Die Category	Drg. No.	58570	
5	Out Side Diameter	Drg. No.	630 mm ✓ Step 002 612 mm ✓	Step length 20 mm ✓
6	Inside Diameter	Drg. No.	520.12 mm ✓	
7	Width of Pellet Die	Drg. No.	186 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x3 mm   13x8x3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No of holes = 12 Both Side
12	Tapping PCD		565 mm ✓	
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 mm ✓	Tapping Depth: 18.6 ✓
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 4/10/24

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

Counter = 60

1	Counter Sinking Depth & Finish	OK							Low = 25 ✓
2	External Relief Dia	4.5 mm ✓	Outside 3-3 ✓		Inner				
3	External Relief Depth		19 mm ✓		15 mm ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		4	10	24				

**Inspected By (Sign) & Date**

Ravi 4/10/24

Reviewed by (Engineer-CNC)  
Sato 4/10/24

Manager-QA