



# 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.		12885 ✓	42/50 ✓
2	Machined By		V.T.L. N/C Shop	Drg No. 13.D.805
3	Pallet Die No.		13432 (6.0) ✓	Rev 2.0 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 ✓	Step 00, 492 ✓
6	Inside Diameter	Drg. No.	420.12 ✓	Step length 17.5 ✓
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 ✓	12x8x3 ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		454 ✓	Tapping H. of Holes, 2 Both Side
13	Tapping Hole Diameter		0314" - Check by 0314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 ✓	Tapping Depth = 16.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 21/07/24

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° Low 15 ✓
2	External Relief Dia	6.5 ✓	Outside (2-2)		Inner			
3	External Relief Depth		14 ✓		8 ✓			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		7	10	24			

### Inspected By (Sign) & Date

Ravi 21/07/24

Reviewed by (Engineer-CNC)

Manager-QA