



# 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.		13182 ✓	32/43/50 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. Lark 5310 ✓
3	Pallet Die No.		13266 (4.0) ✓	
4	Die Category	Drg. No.	Endside	
5	Out Side Diameter	Drg. No.	62.00 ✓ Step 00, 612 ✓	Step length 19.5 ✓
6	Inside Diameter	Drg. No.	52.12 ✓	
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓   13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 ✓	[ Tapping Ho of Holes 12 Both Side ]
13	Tapping Hole Diameter		M20. Check by M20 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 ✓	Tapping Depth 18.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 23/10/24

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								Ravi 23
2	External Relief Dia	U.5MM/5.0MM	[ 4.5MM All Rows ]	[ 5.0MM All Rows ]						
3	External Relief Depth		[ 18MM ]	[ 8MM ]						
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	10	24					
Inspected By (Sign) & Date			Ravi 23/10/24							

Reviewed by (Engineer-CNC)  
Sats 23/10/24

Manager-QA