



# 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.		13059	39/5
2	Machined By		V.T.L. n/c Shop	8752 Dy. Insp. Lark 3310
3	Pallet Die No.		11867 (3.5) mm	
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	620 mm Step 02 = 612 mm	Step length 19.5 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.	13x8x5 mm   13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes = 12 Both side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm Tapping Depth = 18.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 19/10/24

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								
2	External Relief Dia	4.0 mm	Outside (3-3)		Inner					
3	External Relief Depth		18 mm		11 mm					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		19	10	24					

### Inspected By (Sign) & Date

Ravi 19/10/24

19/10/24

Reviewed by (Engineer-CNC)

Manager-QA