



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8416

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.		13125	53/58
2	Machined By		V.T.G. N/C Shop	Dy No. 1.3.0.811
3	Pallet Die No.		12396 (B.8) H/H	Rev 2.05
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	636 H/H	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/H	
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565 H/H	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 H/H	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 22/10/24

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						Rev 2.33
2	External Relief Dia	4.3 H/H	Outside 23-35		Inner			
3	External Relief Depth		12 H/H		5 H/H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		22	10	24			

### Inspected By (Sign) & Date

Ravi 22/10/24

Reviewed by (Engineer-CNC)  
Satsar 22/10/24

Manager-QA