



# 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.		13157 ✓	60/65	
2	Machined By		V.T.G. N/A Shop	Drg No. (2.9.2) 7	
3	Pallet Die No.		13023(3.5) ✓	Rev. 00	
4	Die Category	Drg. No.	Jumbo		
5	Out Side Diameter	Drg. No.	79.0mm ✓ Step 0.02 79.0mm ✓	Step length 30.5	
6	Inside Diameter	Drg. No.	66.0mm ✓	Under cut 1mm	
7	Width of Pellet Die	Drg. No.	394mm ✓		
8	Grooves as per Drawing	Drg. No.	21.5x8x8mm ✓ 21.5x8x8mm ✓		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		N/A Shop	Tapping No. of Holes 12 Both Side	
12	Tapping PCD		725mm		
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 31.4mm Tapping Depth 29.8		
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 9/11/24	2 Slot 32.1mm width 8mm Deep Both Side	
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 - 2 Hole Colused		
Note : Mark the defective holes/Missed holes with the help of Permanent Marker					
1	Counter Sinking Depth & Finish	ok		Counter 60° Ravi 51	
2	External Relief Dia	4.0mm	Outside (3-3)	Inner	
3	External Relief Depth		12mm	5mm	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		9	11	24
Inspected By (Sign) & Date			Ravi 9/11/24		

Reviewed by (Engineer-CNC) *Satish 9/11/24*

Manager-QA