



# 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.		13424 ✓	28/45
2	Machined By		N.T.C. N/C Shop	Drill No. 1.2.0.15430
3	Pallet Die No.		12509(3.0) N/C	Rev. 2.00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610 N/C, Step 00, 612 N/C	Step length 20 N/C
6	Inside Diameter	Drg. No.	52.12 N/C	Under cut 1mm
7	Width of Pellet Die	Drg. No.	222 N/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 N/C   13x8x5 N/C	
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 N/C	
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 N/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 28/11/24

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°
2	External Relief Dia	3.5 N/C	Outside (3-3)		Inner		Rev 2.98
3	External Relief Depth		13 N/C		7 N/C		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Ramesh
6	Material Sent For Hardening On Date		28	11	24		

### Inspected By (Sign) & Date

Ravi 28/11/24

Reviewed by (Engineer-CNC)  
Sathya 29/11/24

Manager-QA