



# 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.		13371 ✓	30/50 ✓
2	Machined By		V.T.L. n/c Shop	Dy No. 1.8.0.4 9
3	Pallet Die No.		12575 (4.0) n/c	Rev 2.00 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c	Step OD: 692.4 n/c
6	Inside Diameter	Drg. No.	600.3 n/c / 600.12 n/c	Step length: 19.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 n/c / 12.5 x 8 x 7 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		645 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: 22.3 n/c	Tapping Depth: 20.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 30/11/24

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 - 1 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60  
Row = 32

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 n/c	Outside (3-3)		Inner		
3	External Relief Depth		24 n/c		20 n/c		
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		30	11	24		

**Inspected By (Sign) & Date**

Ravi 30/11/24

Reviewed by (Engineer-CNC)  
Sachin 21/11/24

Manager-QA