



# 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.		13546	412/42
2	Machined By		N.T.L. n/a. Stop	Drilling 630.1112
3	Pallet Die No.		13362 (B-5) 111	Rev: 00
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	504mm, Step 00, 491mm	Step length 1711
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	10x10x5mm / 10x10x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a. Stop	Tapping No. of holes 8 Both Side
12	Tapping PCD		455mm	
13	Tapping Hole Diameter		08/4" Check by 08/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.3mm	Tapping Depth 17.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/12/24

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								Ravi 27
2	External Relief Dia	4.0mm	outside (2-2)	Inner						
3	External Relief Depth		4mm	Nil						
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		11	12	24					

### Inspected By (Sign) & Date

Ravi 11/12/24

Reviewed by (Engineer-CNC)  
 12/12/24

Manager-QA