



# 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.		13422	40/48/55
2	Machined By		V.T.L. H/O Shop	Drg. No. 13.0.1090
3	Pallet Die No.		13819 (3.5) H/O	Rev = 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 H/O, Step 0.2, 792 H/O	Step lengths 26.5
6	Inside Diameter	Drg. No.	660.12 H/O	Grooves cut 2.11 H/O
7	Width of Pellet Die	Drg. No.	324 H/O	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H/O / 21.5 x 8 x 8 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping dia of 4 dia. 12 Bo to side
12	Tapping PCD		725 H/O	
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 H/O Tapping Depth 28.8 H/O	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 16/12/24

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 - 1 Hole Closed

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

Counter, 30

1	Counter Sinking Depth & Finish	OK						Ravi 51
2	External Relief Dia	4.2 H/O / 4.5 H/O	4.2 H/O	All Rows	~ 15 H/O			
3	External Relief Depth		4.5 H/O	All Rows	~ 7 H/O			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Remace			
6	Material Sent For Hardening On Date		18	12	24			

### Inspected By (Sign) & Date

Ravi 16/12/24

Reviewed by (Engineer-CNC)

Manager-QA