



# 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.		13586	39/50	
2	Machined By		V.T.L H/c Shop	Drg No. Lark 3510	
3	Pallet Die No.		12840 (3.0) mm		
4	Die Category	Drg. No.	Ext. outside		
5	Out Side Diameter	Drg. No.	620 mm, Step 002 G12 mm	Step length 19.4	
6	Inside Diameter	Drg. No.	520.12 mm		
7	Width of Pellet Die	Drg. No.	222 mm		
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		H/c Shop		
12	Tapping PCD		565 mm	Tapping No. of holes 12 Both Side	
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 mm	Tapping Depth 18.5 mm	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 18/12/24		
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		
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	ok		Counter = 60° Rozz 38	
2	External Relief Dia	3.5 mm	outside (3-3)	inner	
3	External Relief Depth		17 mm	11 mm	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Purchase		
6	Material Sent For Hardening On Date		18	12	24
Inspected By (Sign) & Date			Ravi 18/12/24		

Reviewed by (Engineer-CNC)

Manager-QA