



# 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.		13677 ✓	413/50
2	Machined By		N.T.L. n/c Shop	Dry run (ask 3555/3570)
3	Pallet Die No.		13669 (4.5) ✓	
4	Die Category	Drg. No.	Septawide	
5	Out Side Diameter	Drg. No.	620 H4, Step 002 612 H4	Step length 19.5
6	Inside Diameter	Drg. No.	520.14 H4 ✓	
7	Width of Pellet Die	Drg. No.	222 H4 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4   13x8x5 H4 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping H. of Holes 12 R.H. Side
12	Tapping PCD		565 H4 ✓	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H4 Tapping Depth 18.6 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 30/12/24

1	As per programme no.		_____
	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 29
2	External Relief Dia	5.0 H4	Outside (3-2)		Inner					
3	External Relief Depth		12 H4		7 H4					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Surface
6	Material Sent For Hardening On Date		30	12	24					

**Inspected By (Sign) & Date**

Ravi 30/12/24

Satya 30/12/24

Reviewed by (Engineer-CNC)

Manager-QA