



# 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.		13728 ✓	32150/6955
2	Machined By		V.T.L. H/c Shop	Drg. No. Lark 2810
3	Pallet Die No.		13688 (30) ✓	
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	619.9 ✓ Step OD, 612 ✓	Step length 19.5 ✓
6	Inside Diameter	Drg. No.	52.12 ✓	
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓ / 13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping no. of holes 12 Both side
12	Tapping PCD		565 ✓	
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 20.2 ✓	Tapping Depth 18.6 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 31/7/24

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 - 3 Hole Closed (A)

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

Counter: 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	13.5 ✓	Outside (3-3)		Inner				
3	External Relief Depth		21 ✓		18 ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Rumare
6	Material Sent For Hardening On Date		31	12	24				

**Inspected By (Sign) & Date**

Ravi 31/7/24

Satish 31/7/24

Reviewed by (Engineer-CNC)

Manager-QA