



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

89/12

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.		13732 ✓	89/40
2	Machined By		N.T.I. H/c Shop	Dy. Insp. Lark 8919
3	Pallet Die No.		13212(3.2) H/c ✓	
4	Die Category	Drg. No.	3820	
5	Out Side Diameter	Drg. No.	500 H/c ✓ Step 002 490.8 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/c ✓	
7	Width of Pellet Die	Drg. No.	182 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c   12x8x3 H/c	
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 = 8 Both Side
12	Tapping PCD		454 H/c ✓	
13	Tapping Hole Diameter		H2 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 H/c	Tapping Depth = 16.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 6/1/25

1	As per programme no.		_____	
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		1 Hole Closed	

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

1	Counter Sinking Depth & Finish	ok						Counter = 60°
2	External Relief Dia	3.8 H/c	outside (2-2)		Inner			Lead = 28
3	External Relief Depth		14 H/c		11 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi ✓			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			6	1	25		

### Inspected By (Sign) & Date

Ravi 6/1/25

Reviewed by (Engineer-CNC)

Manager-QA