



# 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	Specifcation	Observations	Remarks
1	Work Order No.		13368	42/50
2	Machined By		V. T.L. n/c. Shop	Dy No. 1-9-02-71
3	Pallet Die No.		13714(4.0)mm	Rev 2.00
4	Die Category	Drg. No.	@ 9 outside	
5	Out Side Diameter	Drg. No.	619.8mm Step 001 622.6mm	⊕ Tapper 12
6	Inside Diameter	Drg. No.	520.12mm	Step length 17mm
7	Width of Pellet Die	Drg. No.	222mm	Under cot. 1.4mm
8	Grooves as per Drawing	Drg. No.	9x10x4mm   9x10x4mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	
12	Tapping PCD		565mm	Tapping Ho of holes - 12 Rota Side
13	Tapping Hole Diameter		M22 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2mm Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 15/1/25

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

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	4.5mm	outside (3-3)		inner					
3	External Relief Depth		12mm		8mm					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		15	1	25					

### Inspected By (Sign) & Date

Ravi 15/1/25

Reviewed by (Engineer-CNC)

Manager-QA