



# 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.		14045	39/50
2	Machined By		V.T.L H/C Shop	Dy No. 1.2.02 9980
3	Pallet Die No.		13728 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/C	Step 002 - Tapper 12"
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 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 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M20. Check by M20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 8.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 21/1/25

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 Go  
Row 38

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.3 H/C	outside (3-3)		Inner		
3	External Relief Depth		17 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		21	1	25		

### Inspected By (Sign) & Date

Ravi 21/1/25

Satya 21/1/25

Reviewed by (Engineer-CNC)

Manager-QA