



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13887 ✓	35/40/95
2	Machined By		V.T.I. H/c Shop	Drg. No. Lark 3310
3	Pallet Die No.		13829 (U.O) H/c ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 H/c, Step 002 490.8 H/c, Step 125 H/c ✓	
6	Inside Diameter	Drg. No.	420.12 H/c ✓	
7	Width of Pellet Die	Drg. No.	158 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		M20 = Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 18.3 H/c Tapping Depth - 16.5 H/c ✓	
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

1	Counter Sinking Depth & Finish	ok						Counter: 60
2	External Relief Dia	4.5 H/c	Outside (2-2)		Inner			Row: 20
3	External Relief Depth		9 H/c		5 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		25			

### Inspected By (Sign) & Date

Ravi 21/1/25

Satish 21/1/25

Reviewed by (Engineer-CNC)

Manager-QA