



# 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.		13855 ✓	36/40/299
2	Machined By		V.T.L. H/c Shop	Drg No. Lark 2310
3	Pallet Die No.		13215 (3.5) H/H	
4	Die Category	Drg. No.	320	
5	Out Side Diameter	Drg. No.	499.9 H/H Step OD = 490.9 H/H	Step length 12.4
6	Inside Diameter	Drg. No.	420.12 H/H	
7	Width of Pellet Die	Drg. No.	182 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H   12x8x3 H/H	
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/H	
13	Tapping Hole Diameter		M2 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.2 H/H Tapping Depth = 16.5 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 23/1/25

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 - 1 Hole Closed (A)

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

Counter 260

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.0 H/H	Outside (2-2)		Inner					
3	External Relief Depth		8 H/H		4 H/H					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		23	1	25					

### Inspected By (Sign) & Date

Ravi 23/1/25

Reviewed by (Engineer-CNC)

Manager-QA