



# 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.		13883 ✓	
2	Machined By		V.T.L. M/C Shop	89/40/8195 Dy. No. Lark 3310
3	Pallet Die No.		13227 (3.0) M/C	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.8 M/C	Step 00. 490.8 M/C
6	Inside Diameter	Drg. No.	420.12 M/C	Step length 17.4
7	Width of Pellet Die	Drg. No.	158 M/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 M/C	12x8x3 M/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		454 M/C	Tapping No. of Holes. 8 Both Side
13	Tapping Hole Diameter		M20.1 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 M/C	Tapping Depth 6.6
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 Colused

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

1	Counter Sinking Depth & Finish	ok						Counter Sink
2	External Relief Dia	3.5 M/C	Outside (2.2)		Inner			Row 2 & 4
3	External Relief Depth		14 M/C		11 M/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		23	1	25			

### Inspected By (Sign) & Date

Ravi 23/1/25

Satyam 23/1/25

Reviewed by (Engineer-CNC)

Manager-QA