



# 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.		13946 ✓	44/50 ✓
2	Machined By		V. T. L. H/c Shop	Dy. No. 1-3.0.150
3	Pallet Die No.		13159 (4.0) H/c ✓	Rev. 00 ✓
4	Die Category	Drg. No.	7ER	
5	Out Side Diameter	Drg. No.	730 H/c ✓	Step OD, 742.4 H/c ✓
6	Inside Diameter	Drg. No.	630.12 H/c ✓	630.14 H/c ✓
7	Width of Pellet Die	Drg. No.	290 H/c ✓	Step length, 23 H/c ✓
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c ✓	15x8x5 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: 16 Both Side
12	Tapping PCD		685 H/c ✓	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3 H/c ✓	Tapping Depth: 18.8 H/c ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 28/1/25

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 Calused

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

Counters: 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 H/c ✓	Outside (3-3)		Inner					
3	External Relief Depth		14 H/c ✓		6 H/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		28	1	25					
Inspected By (Sign) & Date		Ravi 28/1/25								

Reviewed by (Engineer-CNC)

Manager-QA