



# 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.		14133 ✓	31/40
2	Machined By		V.T.L. N/C Shop	8/19
3	Pallet Die No.		13566 (2.8) ✓	Dr. H. Lark 3/10
4	Die Category	Drg. No.	8912	
5	Out Side Diameter	Drg. No.	500mm Step 00, 490.8mm Step length 17.5	
6	Inside Diameter	Drg. No.	420.12mm (Bar Tapper 3.2) ✓	
7	Width of Pellet Die	Drg. No.	182mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3mm   12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of Holes = 8 Back Side
12	Tapping PCD		454mm ✓	
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: 18.3mm Tapping Depth: 16.5mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Soni 17/2/25

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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	3.3mm	outside (2.2)	Inner				Row = 31
3	External Relief Depth		15mm	9mm				
4	Inspection Done Before Hardening By (Name)							Soni
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		17	2	25			

### Inspected By (Sign) & Date

Soni 17/2/25

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Reviewed by (Engineer-CNC)

Manager-QA