



# 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.		14230	30/40
2	Machined By		V.T.L. H/c Shop	3195
3	Pallet Die No.		13299 (B.O.)	Dr. H/c Lark 3310
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.8 mm	Step OD, 490.8 mm
6	Inside Diameter	Drg. No.	420.12 mm	Step length: 17.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 mm	12.8 x 3 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 mm	Tapping No. of Holes 2 Both Side
13	Tapping Hole Diameter		M20.2 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 18.3 mm	Tapping Depth, 16.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Sasi 19/2/25

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	3.3 mm	outside (2.2)		inner			low = 24
3	External Relief Depth		13 mm		10 mm			
4	Inspection Done Before Hardening By (Name)							Sasi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		19	2	25			

### Inspected By (Sign) & Date

Sasi 19/2/25

Reviewed by (Engineer-CNC)

Manager-QA