



# 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.		14201	45/50
2	Machined By		V.T.L. n/c Shop	Drilled 18.9.2006
3	Pallet Die No.		14174 (2.2) n/c	Rev 2-00
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	62.0 n/c, Step 00. 62.8 n/c	Tapper 12
6	Inside Diameter	Drg. No.	52.0 1.2 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	22.2 n/c	Under cut 1.4 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	Tapping No of holes 12 Back Side
13	Tapping Hole Diameter		n/c - Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 n/c	Tapping Depth 18.0 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 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 - Hole Closed

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

Counter: 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.8 n/c	Outside (3-3)		Inner			
3	External Relief Depth		12 n/c		5 n/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		19	2	25			

### Inspected By (Sign) & Date

Ravi 19/2/25

Satish 19/2/25

Reviewed by (Engineer-CNC)

Manager-QA