



# 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.		10181	50/50
2	Machined By		V.T.L. N/C Stop	Drg No. 1.9.02.289
3	Pallet Die No.		10794 (3.5)H	Rev 2.00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620 H Step OD. 622.3	Tapping 12°
6	Inside Diameter	Drg. No.	520.12 H	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 H	Enden cut 21.15 H
8	Grooves as per Drawing	Drg. No.	14x8x5 H / 14x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Stop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		M20x C-back by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.4 H Tapping Depth 20.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/9/23

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							
2	External Relief Dia	4.0 H	Outside (3-3)		Inner				
3	External Relief Depth		5 H		Mill				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		2	9	23				

Inspected By (Sign) & Date

Ravi 21/9/23

Reviewed by (Engineer-CNC)

Manager-QA