



# 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.		10426	36/50
2	Machined By		V.T.L. H/C Shop	Dy. No. Lark 355
3	Pallet Die No.		10842 (3.0) H/C	
4	Die Category	Drg. No.	2 outside	
5	Out Side Diameter	Drg. No.	620 H/C 81 cp 002 612 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13-8-5 H/C   13-8-5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H/C of holes = 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M2-2 Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Rept. 20.4 H/C Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 14/10/23	
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		low = 38
2	External Relief Dia	3.5 H/C	Outside (3-3)	Inner
3	External Relief Depth		20 H/C	14 H/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		14	10 23
Inspected By (Sign) & Date			Ravi 14/10/23	

Reviewed by (Engineer-CNC) *Satish* 14/10/23

Manager-QA