



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10435	40/45
2	Machined By		V.T.G. H/C Shop	Drg No. 1.5.0.904
3	Pallet Die No.		11145 (3.0)mm	Rev 2.00
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	509.8mm Step 00 = 498.88 Tapped 212	
6	Inside Diameter	Drg. No.	420.12mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	181.9mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 18x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 8 Both side
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4mm Tapping Depth 16.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Pasi 17/10/23

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 - 1 Hole Colored

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

1	Counter Sinking Depth & Finish	ok							Rep=30
2	External Relief Dia	3.5mm	Outer side (2-2)		Inner				
3	External Relief Depth		11mm		5mm				
4	Inspection Done Before Hardening By (Name)								Pasi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		17	10	23				

### Inspected By (Sign) & Date

Pasi 17/10/23

Reviewed by (Engineer-CNC)  
Sethi 17/10/23

Manager-QA