



# 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.		10487 ✓	40/50
2	Machined By		V.T.L. N/C Shop ✓	Dr. No. = Lark 3310 ✓
3	Pallet Die No.		10831 (G.O) ✓	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620mm ✓ Step OD = 612mm ✓	Step length = 19.4 ✓
6	Inside Diameter	Drg. No.	520.14mm ✓	
7	Width of Pellet Die	Drg. No.	229mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of holes = 12 Both Side ✓
12	Tapping PCD		565mm ✓	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4mm Tapping Depth = 18.8 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/10/23

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								Rav = 23
2	External Relief Dia	6.5mm ✓	outside (3-3)		Inner					
3	External Relief Depth		16mm ✓		10mm ✓					
4	Inspection Done Before Hardening By (Name)				Ravi ✓					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date			31	10	23				

Inspected By (Sign) & Date

Ravi 31/10/23

Reviewed by (Engineer-CNC)

Manager-QA