



# 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.		10699	35/40
2	Machined By		V.T.L. N/C Shop	Drilled I.S.C. 95GT
3	Pallet Die No.		10401 (3.0) N/C	Rev 2.01
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 N/C Step OD = 492.8	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 N/C	
7	Width of Pellet Die	Drg. No.	182 N/C	
8	Grooves as per Drawing	Drg. No.	10x10x4 N/C   10x10x4 N/C	
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 = 8 Both Side
12	Tapping PCD		455 N/C	
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 = 18.4 N/C	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 20/11/23

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							Ravi 20
2	External Relief Dia	3.5 N/C	outside (2.2)		inner				
3	External Relief Depth	/	11 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		20		11		23		

**Inspected By (Sign) & Date**

Ravi 20/11/23

Reviewed by (Engineer-CNC)

Manager-QA