



# 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.		10712 ✓	31/50 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 18.02.276
3	Pallet Die No.		11407 (2.8) ✓	Keep ok ✓
4	Die Category	Drg. No.	S33TD	
5	Out Side Diameter	Drg. No.	680 ✓, Step OD = 623.2 ✓	Tapber = 12°
6	Inside Diameter	Drg. No.	520.12 ✓	Step length 20 ✓
7	Width of Pellet Die	Drg. No.	186 ✓	Undercut = 1.6 ✓
8	Grooves as per Drawing	Drg. No.	13x8x3 ✓   13x8x3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Ho of holes 12 Both Side
12	Tapping PCD		565 ✓	
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 = 20.8 ✓ Tapping Depth = 19 ✓	
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 22/11/23

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 23
2	External Relief Dia	3.1 ✓	outside (3.3)		Inner					
3	External Relief Depth		25 ✓		19 ✓					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		22	11	23					

**Inspected By (Sign) & Date**

Ravi 22/11/23

Sethi 22/11/23

Reviewed by (Engineer-CNC)

Manager-QA