



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6715

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.			
2	Machined By		11001	
3	Pallet Die No.		V.T.L H/c Shop	37159
4	Die Category	Drg. No.	11474 (3.5) H/c	Drg No. Lark 3810
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	620 H/c Step OD = 612 H/c	Step length 19.5 H/c
7	Width of Pellet Die	Drg. No.	520.12 H/c	
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c   13x8x5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No of holes 12 Both Side
13	Tapping Hole Diameter		565 H/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 21.2 H/c	Tapping Depth = 18.7
17	Visual Inspection Before Gun Drilling		Yes	

### Inspected By (Sign) & Date

Ravi 31/1/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
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				Counter 60°
2	External Relief Dia	4.0 H/c	outside (3-3)			Inner
3	External Relief Depth		17 H/c			13 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			3	1	24

### Inspected By (Sign) & Date

Ravi 31/1/24

*[Signature]*  
31/1/24

Reviewed by (Engineer-CNC)

Manager-QA