



# 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.		11004	24/40
2	Machined By		V.T.U H/C Shop	Dr. Has look 23/7
3	Pallet Die No.		11508 (3.5)H4	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4mmH4, Step 00, 3.95H4	Step Length 14.4
6	Inside Diameter	Drg. No.	3.20.12 H4	
7	Width of Pellet Die	Drg. No.	142 H4	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 H4   15.5x7x2 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of Hole - B Both Side
12	Tapping PCD		355 H4	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 81.8 H4 Tapping Depth 19 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 12/1/24

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

Counter = 600

1	Counter Sinking Depth & Finish	ok							Ravi 18
2	External Relief Dia	3.8 H4	outside (2-2)		Inner				
3	External Relief Depth		20 H4		16 H4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forance
6	Material Sent For Hardening On Date			12	1	24			

**Inspected By (Sign) & Date**

Ravi 12/1/24

Reviewed by (Engineer-CNC)  
Sati 12/1/24

Manager-QA