



# 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.		9680	
2	Machined By		V.T.L n/c Shop	30/42/50 3355
3	Pallet Die No.		10036 (4.0)mm	Drilled Lark 3310
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620mm	
6	Inside Diameter	Drg. No.	Step 00, 612mm	Step lengths 19.4
7	Width of Pellet Die	Drg. No.	520.12mm	
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm   13x8x5mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm	Tapping No of holes 12 Both Side
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 18.8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Pass: 10/7/23

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							Row = 31
2	External Relief Dia	4.5mm / 5.0mm	4.5mm All Lines	5.0mm All Lines					
3	External Relief Depth		20mm	8mm					
4	Inspection Done Before Hardening By (Name)		Pass:						
5	Material Sent For Hardening By (Name)		Lark For name						
6	Material Sent For Hardening On Date		10	7	23				

### Inspected By (Sign) & Date

Pass: 10/7/23

Reviewed by (Engineer-CNC)

Manager-QA