



# 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.		11174	45/50
2	Machined By		N.T.L. H/c Shop	Dy No. 102
3	Pallet Die No.		11602 (4.5) H/H	Per 200
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/H, Step 00. Tapper, 12" Step length 18	
6	Inside Diameter	Drg. No.	520.12 H/H	
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H20 - Check by H20 Bit	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 H/H Tapping Depth 18.2 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### 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	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters 20

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.8 H/H	Outside (3-3)		Inner				
3	External Relief Depth		13 H/H		8 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Ramore				
6	Material Sent For Hardening On Date		31	1	24				

### Inspected By (Sign) & Date

Ravi 31/1/24

Reviewed by (Engineer-CNC)

Manager-QA