

69627878



# 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.		11238 ✓	40/50
2	Machined By		V.T.L. n/c Shop	Drg No I.P.C. 12501
3	Pallet Die No.		11215 (3-5) ✓	Revol
4	Die Category	Drg. No.	M. Jumbo	⊙
5	Out Side Diameter	Drg. No.	7mm n/c Step OD: 692.7mm	Step length: 19.8
6	Inside Diameter	Drg. No.	600.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x8x7 mm / 12x8x7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		640mm	
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: 21.4mm	Tapping Depth: 19.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 15/8/24*

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

1	Counter Sinking Depth & Finish	ok						Counter: 60
2	External Relief Dia	11.0mm ✓	Outside (3-3)		Inner			Low: 35
3	External Relief Depth		17mm		10mm			
4	Inspection Done Before Hardening By (Name)							Ravi ✓
5	Material Sent For Hardening By (Name)							Lark Porone
6	Material Sent For Hardening On Date		15	2	24			

Inspected By (Sign) & Date *Ravi 15/8/24*

*[Signature]*  
 15/8/24  
 Reviewed by (Engineer-CNC)

Manager-QA