



# 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.		10824	75/75
2	Machined By		V.T.L. n/c Shop	Dr. No. 18.02.891
3	Pallet Die No.		11776 (8.0) n/c	Revised
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1061 n/c, Step 002 1041 n/c	Tapping 4
6	Inside Diameter	Drg. No.	911.2 n/c	Step length 29 n/c
7	Width of Pellet Die	Drg. No.	387.8 n/c	
8	Grooves as per Drawing	Drg. No.	33x10x9.9 n/c / 33x10x9.9 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	1 n/c Deep Back side
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		99.5 n/c	of holes 16
13	Tapping Hole Diameter		1242, Check by 124 Bolt	Back side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 41.4 n/c	Tapping Depth 38.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/3/24

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 63
2	External Relief Dia	9.0 n/c	Outside (23-3)	Inner			Row 2 30
3	External Relief Depth		8 n/c	Nil			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		11	3	24		

Inspected By (Sign) & Date

Ravi 11/3/24

Satya 11/3/24

Reviewed by (Engineer-CNC)

Manager-QA