



# 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.		11458	50/50
2	Machined By		V.T.L. n/c Shop	Dy. H. Lark
3	Pallet Die No.		11896 (5.0) n/c	
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 n/c, Step 00 = 612 n/c	Step length = 19.4
6	Inside Diameter	Drg. No.	520.12 n/c / 520.14 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
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 Back Side
12	Tapping PCD		565 n/c	
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 20.8 n/c	Tapping Depth 18.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 14/3/24

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 = 60° Lower 26
2	External Relief Dia	5.3 n/c	88-33	Outside	Inner		
3	External Relief Depth		5 n/c		Null		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Insurance
6	Material Sent For Hardening On Date		14	3	24		

Inspected By (Sign) & Date Ravi 14/3/24

Reviewed by (Engineer-CNC)  
[Signature] 14/3/24

Manager-QA