



# 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.		11448 ✓	48/50 ✓
2	Machined By		V.T.L. H/c Shop	Dr. H/c L.S.D. 18
3	Pallet Die No.		11055 (6.0) H/c	Rev. 02 ✓
4	Die Category	Drg. No.	3210	
5	Out Side Diameter	Drg. No.	520 H/c Step 002 491 H/c	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	18 22 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12+8+3 H/c } 12+8+3 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes - 8 Both Side
12	Tapping PCD		454 H/c ✓	
13	Tapping Hole Diameter		H 20 = Check by H2 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19 H/c Tapping Depth 12.5 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/3/24

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

Counter 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.3 H/c	outside (2-2)		inner					
3	External Relief Depth		14 H/c		8 H/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date			18	3	24				

Inspected By (Sign) & Date

Ravi 18/3/24

Reviewed by (Engineer-CNC)

Manager-QA