



# 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.		11546	38/45
2	Machined By		V.T.L. M/c Shop	Dy No. 1-2-00 543-
3	Pallet Die No.		11968 (3-0) M/c	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610 M/c, Step OD = 611.8 M/c	Step length 20 M/c
6	Inside Diameter	Drg. No.	520.12 M/c	Under cut 1 M/c
7	Width of Pellet Die	Drg. No.	222 M/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 M/c / 13x8x5 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping Holes of Holes 2/2 Both Side
12	Tapping PCD		565 M/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 20.6 M/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 21/3/24

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
2	External Relief Dia	3.3 M/c	outside (3-3)		Inner			Rev = 38
3	External Relief Depth		13 M/c		7 M/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		21	3	24			

**Inspected By (Sign) & Date**

Ravi 21/3/24

Reviewed by (Engineer-CNC)  
21/3/24

Manager-QA