



# 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

7169

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11548	40/47
2	Machined By		V.T.L. H/c Shop	Drg No. 1-2-01 5431
3	Pallet Die No.		11989 (3-0) H/c	Rev. no
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	614 H/c / Step 00 = 612 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	580.14 H/c / 580.9 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes 12 Back Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H/c, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/c	Tapping Depth 18.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Rasi 22/3/24

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	3.5 H/c	Outside (3-3)	Inner			Per 2 38
3	External Relief Depth		13 H/c	7 H/c			
4	Inspection Done Before Hardening By (Name)		Rasi				
5	Material Sent For Hardening By (Name)		Lark Purchase				
6	Material Sent For Hardening On Date		22	3	24		

### Inspected By (Sign) & Date

Rasi 22/3/24

Reviewed by (Engineer-CNC)

Manager-QA