



# 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.		11339	27/55
2	Machined By		V.T.L. H/c Shop	Drg. No. 12.0.594
3	Pallet Die No.		12182 (4.5) H/c	Rev. 00
4	Die Category	Drg. No.	SRD	
5	Out Side Diameter	Drg. No.	530 H/c	Step OD, 491 H/c Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182.1 H/c	
8	Grooves as per Drawing	Drg. No.	10x8x3 H/c   10x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping W. of holes - 8 Back side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		23/4" - Check by 23/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.5 H/c	Tapping Depth: 17 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 29/3/24

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 = 6
2	External Relief Dia	5.5 H/c	outside (2-2)	Inner			Rev 2 23
3	External Relief Depth		32 H/c	28 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		29	3	24		

### Inspected By (Sign) & Date

Ravi 29/3/24

Reviewed by (Engineer-CNC)

Manager-QA