



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11572	42/55
2	Machined By		V.T.L. Np Shop	Dy. No. 68.02 355
3	Pallet Die No.		11027 (4.0) 44	Rev. 2.00
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 44 / Step 00 = 612 44	Step length 204
6	Inside Diameter	Drg. No.	520.14 44 (A)	
7	Width of Pellet Die	Drg. No.	186 44	
8	Grooves as per Drawing	Drg. No.	1348 x 3 44 / 1348 x 3 44	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		565 44	
13	Tapping Hole Diameter		M20 C. Lock by M20 B-11	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 44	Tapping Depth 8-8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 30/3/24

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 - 2 Hole Closed (A)	

**Note : Mark the defective holes/Missed holes with the help of Permanent Marker**

1	Counter Sinking Depth & Finish	OK						Rev. 2.25
2	External Relief Dia	4.5 44	Outside (3-3)		Inner			
3	External Relief Depth		17 44		13 44			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		30	3	24			

**Inspected By (Sign) & Date**

Ravi 30/3/24

Reviewed by (Engineer-CNC)

Manager-QA