



# 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.		11494	35/50
2	Machined By		V.T.L. N/C Shop	Dry H. 2 18.5 932
3	Pallet Die No.		11937 (2.8) H	Revered
4	Die Category	Drg. No.	Turnbo	
5	Out Side Diameter	Drg. No.	760 H / Step OD 2 801 H	Tapper 9.5"
6	Inside Diameter	Drg. No.	660 1/2 H	Step length 20 H
7	Width of Pellet Die	Drg. No.	316 H	Width 2 20 5 H
8	Grooves as per Drawing	Drg. No.	18x9x6 H / 18x9x6 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping N. of H. 2 12 Both side
12	Tapping PCD		725 H	
13	Tapping Hole Diameter		H 20 2 Check by H 20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.8 H	Tapping Depth 20.8
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 - 5 Hole Closed

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

Counter 59

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	3.3 H	Outside (3.3)	Inner				
3	External Relief Depth		20 H	15 H				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Porrace					
6	Material Sent For Hardening On Date		29	3	24			

### Inspected By (Sign) & Date

Ravi 29/3/24

Sats... 29/3/24  
Reviewed by (Engineer-CNC)

Manager-QA