



# 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.		11560	
2	Machined By		V.T.L H/C Shop	33/40
3	Pallet Die No.		11585 (3.0) H/C	Dy. No. Lark 3370
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4100 H/C, Step OD = 395 H/C	Step length 14.4
6	Inside Diameter	Drg. No.	320.12 H/C	
7	Width of Pellet Die	Drg. No.	142 H/C	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/C	15.5 x 7 x 2 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		355 H/C	Tapping No. of holes 8 Both side
13	Tapping Hole Diameter		H16 2 Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 H/C	Tapping Depth = 19 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/4/24

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							Counters 60
2	External Relief Dia	3.5 H/C	60 Side (2-2)	Inner					Row 2 20
3	External Relief Depth		13 H/C	7 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								1 4 24

Inspected By (Sign) & Date

Ravi 11/4/24

*Signature*  
11/4/24

Reviewed by (Engineer-CNC)

Manager-QA