



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7758  
 Form No. CNC/QA/FM/12  
 Rev. No. 01  
 Rev. Date 31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11683/	24/40
2	Machined By		V.T.L H/C Shop	9109 Dy. Insp. Lark 3710
3	Pallet Die No.		11582 (3-5) H/C	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/C, Step OD = 395 H/C	Step length 14.5
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	Tapping No. of Holes 8 Both Side
12	Tapping PCD		355 H/C	
13	Tapping Hole Diameter		H/C - Check by H/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 20.7 H/C	Tapping Depth 18.5 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 5/4/24

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						Counter 260
2	External Relief Dia	3.8 H/C	Outside (2-2)	Inner				
3	External Relief Depth	20 H/C		16 H/C				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forging					
6	Material Sent For Hardening On Date		5	4	24			
Inspected By (Sign) & Date		Ravi 5/4/24						

Reviewed by (Engineer-CNC)

Manager-QA