



# 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.		11711	60/40
2	Machined By		V.T.L. H/c Shop	Drg. No. 1.85215062
3	Pallet Die No.		11314 (4.0) H/c	Res. 20g
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c, Step OD = 493.58	12° Step length 13 H/c
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158.1 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c   12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes. 8 Back Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.8 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 12/4/24

- As per programme no.
- Gun Drilling Work Completed On
- Hole Finish In Gun Drilling
- Defective Holes (If Any)

Marked

ok  
ok  
No

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

1	Counter Sinking Depth & Finish	ok					Counter 60 Res. 20
2	External Relief Dia	4.5 H/c	outside (2-2)	Inner			
3	External Relief Depth		4 H/c	Mill			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Purchase
6	Material Sent For Hardening On Date		12	4	24		

Inspected By (Sign) & Date

Ravi 12/4/24

Reviewed by (Engineer-CNC)

Manager-QA