



# 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.		11745	28/50
2	Machined By		V.T.L. H/C Shop	Drg No. L.E.G. 11980
3	Pallet Die No.		11645 (2.8) H/C	Rev: 02
4	Die Category	Drg. No.	585TD	
5	Out Side Diameter	Drg. No.	62.1 H/C Step OD = 62.1 H/C	Tapper = 12
6	Inside Diameter	Drg. No.	58.12 H/C	Step length = 2 H/C
7	Width of Pellet Die	Drg. No.	186 H/C	Under cut = 2 H/C
8	Grooves as per Drawing	Drg. No.	13x8x3 H/C / 13x8x3 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 = 12 Both Side
12	Tapping PCD		565 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 = 20.8 H/C	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 18/4/24

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 - Hole Closed

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

1	Counter Sinking Depth & Finish	OK							Counter = 6
2	External Relief Dia	3.3 H/C	Outside (3-3)		Inner				
3	External Relief Depth		25 H/C		22 H/C				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		18	4	24				

### Inspected By (Sign) & Date

Ravi 18/4/24

Reviewed by (Engineer-CNC)  
Satsou 18/4/24

Manager-QA