



# 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.			
2	Machined By		11817	33/50
3	Pallet Die No.		V. T. L. N. C. Shop	Drg No. L-20-7980
4	Die Category	Drg. No.	12109 (30) mm	Rev. 2.00
5	Out Side Diameter	Drg. No.	8.2 mm	
6	Inside Diameter	Drg. No.	6.2 mm Step OD, Tappers 12° Step length = 18	
7	Width of Pellet Die	Drg. No.	5.20-14 mm	
8	Grooves as per Drawing	Drg. No.	2.22 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm / 13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of Holes = 12
12	Tapping PCD		56.5 mm	Both Side
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 Rept. 20.8 mm Tapping Depth = 18.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Pooi 16/5/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		2 Hole Closed

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

1	Counter Sinking Depth & Finish	ok								Counten = 60
2	External Relief Dia	3.5 mm	outside (2.3)		inner					Rev = 38
3	External Relief Depth		2.3 mm		1.7 mm					
4	Inspection Done Before Hardening By (Name)									Pooi
5	Material Sent For Hardening By (Name)									Lark Kurnare
6	Material Sent For Hardening On Date			16	5	24				

### Inspected By (Sign) & Date

Pooi 16/5/24

Satya 16/5/24

Reviewed by (Engineer-CNC)

Manager-QA