



# 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.		11928	36/4
2	Machined By		V.T.C. H/c Shop	Drg No. (3.0) 705
3	Pallet Die No.		11816(3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c Step 00 = 491 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c / 12 x 8 x 3 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		454 H/c	
13	Tapping Hole Diameter		23/4" - Check by 23/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.2 H/c	Tapping Depth: 17.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 18/5/24

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

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

1	Counter Sinking Depth & Finish	ok						Counter 60 Low 294
2	External Relief Dia	3.5 H/c	outside (2-2)		Inner			
3	External Relief Depth		10 H/c		4 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Purnace			
6	Material Sent For Hardening On Date		18	5	24			

**Inspected By (Sign) & Date**

Ravi 18/5/24

Satyam  
18/5/24

Reviewed by (Engineer-CNC)

Manager-QA