



# 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.		10000	40/55/80
2	Machined By		V.T.L n/c Shop	Dy No. 11.32 859
3	Pallet Die No.		10862 (8.0) n/c	Reused
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730 n/c / 732 n/c Step on	632 n/c
6	Inside Diameter	Drg. No.	572.12 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	219 n/c	
8	Grooves as per Drawing	Drg. No.	67x8x8 n/c / 28x8x8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No of Holes: 6
12	Tapping PCD		650 n/c	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and	Thrd Side One Side
15	Tapping Hole Depth		Drill Depth 40.8 n/c	Tapping Depth 38.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 31/7/23

1	As per programme no.			13107 36.1 n/c width 19.1 n/c Depth
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No Hole Colored (OK)	

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

1	Counter Sinking Depth & Finish	OK						Ravi
2	External Relief Dia	8.5 n/c / 9.0 n/c	8.5 n/c All Lines	9.0 n/c All Lines				
3	External Relief Depth		40 n/c	25 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		31	7	23			

**Inspected By (Sign) & Date**

*[Signature]*  
31/7/23

Ravi 31/7/23

Reviewed by (Engineer-CNC)

Manager-QA