



# 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.			
2	Machined By		12303 ✓	27/50 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Drg. No. 62.02 415
4	Die Category	Drg. No.	12319 (5.0) H/c ✓	Rev. 01 ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	5.0mm ✓ Step 00. 499mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	42.12mm ✓	Step length 2mm ✓
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm   12x8x3mm ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454mm ✓	Tapping No. of holes 8 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 Depth 18.3mm	Tapping Depth 16.5mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 9/8/24

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°
2	External Relief Dia	5.5mm	Outside 2-2	Inner				Rep. 17
3	External Relief Depth		28mm	23mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		9	7	24			

### Inspected By (Sign) & Date

Ravi 9/7/24

Satya 9/7/24

Reviewed by (Engineer-CNC)