



# 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.		12924	28/10
2	Machined By		V. T. L. N/C Shop	Drill No. 1.8.0.21
3	Pallet Die No.		12458 (2.5) H	Revised
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H	Step OD, 499 H, Tappess=12
6	Inside Diameter	Drg. No.	420.12 H	Step length 17 H
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H / 12x8x3 H	
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 - 8 Both Side
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		0316" - Check by 0316" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.3 H	Tapping Depth: 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 20/9/24

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 En. 20
2	External Relief Dia	2.8 H	Outside (2.2)		Inner			Rev = 28
3	External Relief Depth		18 H		12 H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		20	9	24			

### Inspected By (Sign) & Date

Ravi 20/9/24

*[Signature]*  
20/9/24

Reviewed by (Engineer-CNC)

Manager-QA