



# 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.		12964 ✓	35/40 ✓
2	Machined By		V.T.L N/C Shop	Dy. Insp. Lark 28.10 ✓
3	Pallet Die No.		8927 (5.0) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm ✓ Step 00.49 mm ✓	Step length 17.5 ✓
6	Inside Diameter	Drg. No.	420.14 mm   420.2 mm (A)	
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm   12x8x3 mm	
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 mm ✓	
13	Tapping Hole Diameter		120 - Crack by 120 Bell ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.4 mm	Tapping Depth: 16.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 21/9/24

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 = 60° Raz = 17 ✓
2	External Relief Dia	5.5 mm ✓	Outside 22-22	Inner			
3	External Relief Depth		10 mm ✓	5 mm ✓			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		21	9	24		

### Inspected By (Sign) & Date

Ravi 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA