



# 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.		10023	40/40
2	Machined By		V.T.G. N/C Shop	Dr. No. L.E.C. 15062
3	Pallet Die No.		9773 (5.0)mm	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm mm	
6	Inside Diameter	Drg. No.	Step 002 Tapper 12° Step length 18mm	
7	Width of Pellet Die	Drg. No.	42.12mm	
8	Grooves as per Drawing	Drg. No.	157.8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm   12x8x3mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No. of Holes: 8 Both Side
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	M20mm Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.4mm Tapping Depth 16.8mm	
17	Visual Inspection Before Gun Drilling		yes ok	

**Inspected By (Sign) & Date**

Ravi 12/8/23

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							
2	External Relief Dia	5.3mm	Outside (2-2)		Inner				Radius 17
3	External Relief Depth		5mm		Mill				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Purvace
6	Material Sent For Hardening On Date			12	8	23			

**Inspected By (Sign) & Date**

Ravi 12/8/23

*(Signature)*  
12/8/23

Reviewed by (Engineer-CNC)

Manager-QA