



# 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.		12938	40/55
2	Machined By		V.T.L n/c Shop	Dry Hole 6-2-C2/4924
3	Pallet Die No.		12647 (5.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Ends wide	
5	Out Side Diameter	Drg. No.	630 n/c	Step 00. 612 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 9.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c	13x8x5 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 12 Both Side
12	Tapping PCD		565 n/c	
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 20.4 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/10/24

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

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.5 n/c	outside (3-3)		Inner				
3	External Relief Depth		20 n/c		15 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			1	10	24			

Inspected By (Sign) & Date

Ravi 11/10/24

Reviewed by (Engineer-CNC)

Manager-QA