



# 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.		13006	37/40
2	Machined By		V.T.L. n/c Shop	Drg No. 12450
3	Pallet Die No.		12450 (3.5) n/c	Re 22 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c	Step 0.2-498.88
6	Inside Diameter	Drg. No.	420.12 n/c	Tabbes 12°
7	Width of Pellet Die	Drg. No.	158 n/c	Step length 12 n/c
8	Grooves as per Drawing	Drg. No.	12+8+3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping No of holes 8 Both side
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.4 n/c	Tapping Depth: 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Raw: 30/9/24	
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	
<b>Note : Mark the defective holes/missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	OK		Counter 60
2	External Relief Dia	4.0 n/c	Outside (2.2)	Re 22
3	External Relief Depth		7 n/c	
4	Inspection Done Before Hardening By (Name)		Raw	
5	Material Sent For Hardening By (Name)		Lark Purnore	
6	Material Sent For Hardening On Date		30 9 24	
Inspected By (Sign) & Date			Raw: 30/9/24	

Reviewed by (Engineer-CNC)

Manager-QA