



# 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.		12987 ✓	30/12
2	Machined By		V.T.L. N/C Shop	Dry run 18.0.21
3	Pallet Die No.		12465 (3.0) ✓	Rev: 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4 ✓ Step 002 499 H4	Tapped 2 12°
6	Inside Diameter	Drg. No.	420.12 H4 ✓	Step length 17 H4
7	Width of Pellet Die	Drg. No.	158 H4 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4   12x8x3 H4 ✓	
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 H4 ✓	
13	Tapping Hole Diameter		031/2" 2 Check by 031/2" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 H4	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 9/10/24	
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				
1	Counter Sinking Depth & Finish	OK		Counter 60° Ravi 25
2	External Relief Dia	0.5 H4	outside (2-2)	inner
3	External Relief Depth		13 H4	10 H4
4	Inspection Done Before Hardening By (Name)		✓ Ravi ✓	
5	Material Sent For Hardening By (Name)		Lark Forncare	
6	Material Sent For Hardening On Date		9 10 24	
Inspected By (Sign) & Date			Ravi 9/10/24	

Reviewed by (Engineer-CNC)

Manager-QA