



# 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.		12657	45/50
2	Machined By		V.T.L n/c Shop	Dr. S.D. 276
3	Pallet Die No.		12218 (8.0) n/c	Revised
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c Step OD: 490 n/c	Step length 276
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	159 n/c	
8	Grooves as per Drawing	Drg. No.	11x5x3 n/c / 11x5x3 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 = 8 Both Side
12	Tapping PCD		456 n/c	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.4 n/c	Tapping Depth: 14.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 10/10/24

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 = 12
2	External Relief Dia	8.5 n/c	Outside (2-2)	Inner				
3	External Relief Depth		13 n/c	5 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		10	10	24			

### Inspected By (Sign) & Date

Ravi 10/10/24

Reviewed by (Engineer-CNC)

Manager-QA