



# 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.		13047	B1/40
2	Machined By		V.T.L n/c Shop	Dry No. L.R.D. 779
3	Pallet Die No.		12531 (3-5) n/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 n/c, Step OD: 383.5 n/c	Step length 9.5
6	Inside Diameter	Drg. No.	315.12 n/c	
7	Width of Pellet Die	Drg. No.	128 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 3 n/c / 12.5 x 8 x 3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	[ Tapping n/c of holes on Both Side ]
12	Tapping PCD		350 n/c	
13	Tapping Hole Diameter		M12 - Check by M12 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 14/10/24

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							Ravi 16
2	External Relief Dia	4.0 n/c	Outside (2-2)		Inner				
3	External Relief Depth		12 n/c		9 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		14	10	24				

Inspected By (Sign) & Date

Ravi 14/10/24

Ravi 14/10/24

Reviewed by (Engineer-CNC)

Manager-QA