



# 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.		13022 ✓	39/50
2	Machined By		V. T. L. H/O Shop	Dry Holes 6-80-998
3	Pallet Die No.		13106 (3.0) H/H	Rev = 00
4	Die Category	Drg. No.	8-4-2-1-10	
5	Out Side Diameter	Drg. No.	620 H/H	Step 00, Tapper, 12°
6	Inside Diameter	Drg. No.	520.12 H/H	Step length, 18.5
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping No. of Holes - 12 Both Side
12	Tapping PCD		565 H/H	
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 H/H	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 - 1 Hole Closed

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter = 60  
Rev = 38

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 H/H	outside (3-3)	Inner			
3	External Relief Depth		17 H/H	11 H/H			
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

Reviewed by (Engineer-CNC)

Manager-QA