



# 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.		INV 1013072	40/40
2	Machined By		N.T.L. H/C Shop	Dyler, L.S.C. 15-62
3	Pallet Die No.		12453 (4.0) H/C	Review
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm H/C Step 00, 498.88	Tabber 12
6	Inside Diameter	Drg. No.	4.20 ± 0.12 H/C	Step length 8mm
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C   12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		4.54 H/C	
13	Tapping Hole Diameter		H202 Check by H202	Tapping No of Holes = 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 H/C	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 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 :</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Country Co
2	External Relief Dia	4.3 H/C	outside 2.29	Row 2
3	External Relief Depth		4 H/C	Inner
4	Inspection Done Before Hardening By (Name)			Mill
5	Material Sent For Hardening By (Name)			Ravi
6	Material Sent For Hardening On Date		30	9
Inspected By (Sign) & Date			Ravi 30/9/24	

Reviewed by (Engineer-CNC)

Manager-QA