



# 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.		12998 ✓	25/42 9109
2	Machined By		V.T.L N/C Shop	Dy. Lark 3910
3	Pallet Die No.		13512 (3.5) ✓	Rev: 00 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4mm ✓ Step OD: 3.95mm ✓	Step length: 18.5 ✓
6	Inside Diameter	Drg. No.	3.9mm ✓	
7	Width of Pellet Die	Drg. No.	14mm ✓	
8	Grooves as per Drawing	Drg. No.	15.5x7x2mm   15.5x7x2mm ✓	
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		355mm ✓	
13	Tapping Hole Diameter		N/C Check by H18 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3mm ✓	Tapping Depth: 18.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 19/10/24	
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 (A)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 60° Len 2.18 ✓
2	External Relief Dia	4.0mm ✓	Outside (3.2) ✓	Inner
3	External Relief Depth		19mm ✓	15mm ✓
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		19   10   24	
Inspected By (Sign) & Date			Sasi 19/10/24	

Sasi 19/10/24

Reviewed by (Engineer-CNC)

Manager-QA