



# 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.		13172 ✓	
2	Machined By		V. T. L. H/c Shop	3215 ✓
3	Pallet Die No.		11655 (2.8) ✓	Dy. No. Lark 8370 ✓
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	620.144 ✓	Step 002 B12.144 ✓
6	Inside Diameter	Drg. No.	520.1244 ✓	Step length 19.5 ✓
7	Width of Pellet Die	Drg. No.	186.144 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x544 ✓	13x8x544 ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56544 ✓	Tapping H/c of Holes 12 Both Side
13	Tapping Hole Diameter		H20, Check by H20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 2144 ✓	Tapping Depth: 18.8 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 15/10/24

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 31
2	External Relief Dia	3.144 ✓	Outside (3-3)		Inner				
3	External Relief Depth		2344 ✓		1844 ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forner
6	Material Sent For Hardening On Date		15	10	24				

### Inspected By (Sign) & Date

Ravi 15/10/24

Reviewed by (Engineer-CNC)

Manager-QA