



# 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.			
2	Machined By		13089	34/46
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. 14027863
4	Die Category	Drg. No.	11870 (3.0) n/c	Revised
5	Out Side Diameter	Drg. No.	38810	
6	Inside Diameter	Drg. No.	612 n/c	Step 002 623.5 n/c
7	Width of Pellet Die	Drg. No.	520.12 n/c	Tabber 12°
8	Grooves as per Drawing	Drg. No.	186 n/c	Step length 2.5
9	Fitting Sizes on CNC Plate	Drg. No.	13.5 x 7.5 x 5.5 n/c	Under cut 5.75 n/c
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Ball	Tabbing No of holes 12
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 21.3 n/c	Tabbing Depth 19.4 n/c
17	Visual Inspection Before Gun Drilling		yes	
			ok	

### Inspected By (Sign) & Date

Ravi 22/10/24

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°
2	External Relief Dia	3.3 n/c	Outside (3-3)		Inner			R 2 30
3	External Relief Depth		18 n/c		12 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		22	10	24			

### Inspected By (Sign) & Date

Ravi 22/10/24

Reviewed by (Engineer-CNC)

Manager-QA