



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13062 ✓	35/55 ✓
2	Machined By		V. T. L. M/c Shop	Drg No. L-20-11952
3	Pallet Die No.		12428 (6.0) H ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	External die	
5	Out Side Diameter	Drg. No.	630 H ✓	Step OD = 680.8 H ✓
6	Inside Diameter	Drg. No.	520.12 H ✓	Tap size 12°
7	Width of Pellet Die	Drg. No.	222 H ✓	Step length 18.5 ✓
8	Grooves as per Drawing	Drg. No.	14x8x10 H ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	14x8x10 H ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565 H ✓	Tapping H of Holes - 12 Back 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 20.4 H ✓	Tapping Depth 18.5 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 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

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

1	Counter Sinking Depth & Finish	OK						Counter sink
2	External Relief Dia	6.5 H ✓	Outside (3-3)		Inner			Rev 2.00
3	External Relief Depth		26 H ✓		20 H ✓			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Pur pose
6	Material Sent For Hardening On Date		19	10	24			
Inspected By (Sign) & Date		Ravi 19/10/24						

Reviewed by (Engineer-CNC)

Manager-QA