



# 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.		13077	42/45
2	Machined By		V.T.L. n/c Shop	Drill No. 1.3.2-904
3	Pallet Die No.		13034(3.0)H	Rao
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	510H	Step length. 18
6	Inside Diameter	Drg. No.	420.12 H	Tap - 12
7	Width of Pellet Die	Drg. No.	182 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H / 12x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 H	Tapping H. of Holes - 8 Both Side
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.4 H	Tabbing Depth. 16.5 H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Rao: 24/10/24

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	3.5 H	outside (2-2)		Inner			Rao = 30
3	External Relief Depth		9 H		3 H			
4	Inspection Done Before Hardening By (Name)							Rao
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		24	10	24			

### Inspected By (Sign) & Date

Rao: 24/10/24

Reviewed by (Engineer-CNC)

Manager-QA