



# 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.		13124	30/40
2	Machined By		V. T. L. n/c Shop	2175 Dy. Hr. Lark 5570
3	Pallet Die No.		12686 (3.0) n/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm n/c	Step length 1.5
6	Inside Diameter	Drg. No.	42.12 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping No. of 4. Pcs 8
13	Tapping Hole Diameter		M20 = Check by M20 Ball	Right Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 n/c	Tapping Depth: 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 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

Counter, Go

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.3 n/c	outside (2-2)		Inner			
3	External Relief Depth		13 n/c		10 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		24	10	24			

### Inspected By (Sign) & Date

Ravi 24/10/24

Reviewed by (Engineer-CNC)

Manager-QA