



# 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.		13252 ✓	50/55
2	Machined By		V.T.L. H/c Shop	Drilling No. 189
3	Pallet Die No.		13516 (4.5) ✓	Pass ✓
4	Die Category	Drg. No.	382	
5	Out Side Diameter	Drg. No.	530mm, Step OD, 498.8mm	Tapper 12
6	Inside Diameter	Drg. No.	480.12mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	182.1mm	
8	Grooves as per Drawing	Drg. No.	18 x 8 x 3mm / 18 x 8 x 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No. of holes 8 Back Side
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4mm	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 29/10/24

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 60  
Pass 22

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.0mm ✓	outside (3-3)	Inner			
3	External Relief Depth		14mm	5mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		29	10	24		

### Inspected By (Sign) & Date

Ravi 29/10/24

Satyam 29/10/24

Reviewed by (Engineer-CNC)

Manager-QA