



# 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.		13261 ✓	23/70 ✓
2	Machined By		V.T.L n/c Shop	Dr. No. 630.377
3	Pallet Die No.		12930 (B.O) n/c	Rev. 03 ✓
4	Die Category	Drg. No.	N. Jamba ✓	
5	Out Side Diameter	Drg. No.	688 n/c ✓	Step 002 697.8 n/c ✓
6	Inside Diameter	Drg. No.	548.1 n/c ✓	Tap length 28.5 ✓
7	Width of Pellet Die	Drg. No.	215.1 n/c ✓	Under cut 1.2 n/c ✓
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 n/c   29.5 x 10 x 8 n/c	(6 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	1 n/c Deep
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		618 n/c ✓	Tapping No. of holes 2
13	Tapping Hole Diameter		n/c ✓	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32.4 n/c ✓	Tapping Depth 30.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 5/11/24

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 = 30°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	9.0 n/c ✓	All Rows						
3	External Relief Depth		37 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		5	11	24				

### Inspected By (Sign) & Date

Ravi 5/11/24

Reviewed by (Engineer-CNC)

Manager-QA