



# 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.		13221 ✓	31/40 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.0-70
3	Pallet Die No.		13121 (2.8) n/c	Revised
4	Die Category	Drg. No.	520	
5	Out Side Diameter	Drg. No.	500 n/c	Step OD, 499 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	Tapper = 12 Step length = 20 n/c
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 n/c	
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 n/c	Tapping H. of holes & Body 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 n/c	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/11/24

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		N=

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

1	Counter Sinking Depth & Finish	ok						Counter 31
2	External Relief Dia	3.3 n/c	Outside (2-25)	Inner				
3	External Relief Depth		15 n/c	9 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forcare					
6	Material Sent For Hardening On Date		11	11	24			

### Inspected By (Sign) & Date

Ravi 11/11/24

Satya 11/11/24

Reviewed by (Engineer-CNC)

Manager-QA