



# 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.			
2	Machined By		13296 ✓	40/50 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Dry No. 12.02 ✓ 452
4	Die Category	Drg. No.	13176 (4.0) H/C ✓	Rev 01 ✓
5	Out Side Diameter	Drg. No.	520 H/C ✓	
6	Inside Diameter	Drg. No.	Step 00, 491.2 H/C ✓	Step length 18.2 ✓
7	Width of Pellet Die	Drg. No.	420.12 H/C ✓	
8	Grooves as per Drawing	Drg. No.	173 H/C ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	10x8.5x5 H/C   10x8.5x5 H/C ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	Tapping No. of holes 2 Body Side
13	Tapping Hole Diameter		455 H/C ✓	
14	Tapping On Second Side	Half pitch of 1st side	Ø3/4" = Check by Ø3/4" Pass ✓	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 H/C ✓	Tapping Depth 18.6 ✓
17	Visual Inspection Before Gun Drilling		yes	
			OK	

### Inspected By (Sign) & Date

Ravi 9/11/24

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 60°

1	Counter Sinking Depth & Finish	OK								Ravi 24
2	External Relief Dia	4.5 H/C ✓	Outside (2-2)		Inner					
3	External Relief Depth		14 H/C ✓		10 H/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			9	11	24				

### Inspected By (Sign) & Date

Ravi 9/11/24

Satya 9/11/24

Reviewed by (Engineer-CNC)

Manager-QA