



# 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.		13161	40/45
2	Machined By		V. T. L. n/c Shop	Drg No. L.S.D. 296
3	Pallet Die No.		12976 (3.0) n/c	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	690 n/c	Step 00, 703 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tabber, 4°
7	Width of Pellet Die	Drg. No.	250 n/c	Step length 23.5
8	Grooves as per Drawing	Drg. No.	24x5x9 n/c / 24x5x9 n/c	Width 6.5 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		655 n/c	Tapping H. of 4.0.12 Both Side
13	Tapping Hole Diameter		MIG - Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 24.4 n/c	Tapping Depth, 22.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/1/24

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							
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		11 n/c		5 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Purchase				
6	Material Sent For Hardening On Date		4	11	24				

### Inspected By (Sign) & Date

Ravi 4/1/24

Saty 5/11/24

Reviewed by (Engineer-CNC)

Manager-QA