



# 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.		13440	50/50
2	Machined By		V.T.L. M/C Shop	Dy. No. 1.20.13760
3	Pallet Die No.		13431 (80)	Rev. No. -
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm Step no: 491mm	Step length 7.4
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm   12x8x3mm	
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, B Both Side
12	Tapping PCD		454mm	
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: 18.3mm	Tapping Depth: 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/11/24

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

1	Counter Sinking Depth & Finish	ok		As per Drawing with Mr Ravi Sahu Team	Counter = 60° Rov = 12
2	External Relief Dia	8.5mm	Outside (3-3)	Inner	
3	External Relief Depth		4mm	Nil	
4	Inspection Done Before Hardening By (Name)		Ravi		Discovered with Sachin Sir
5	Material Sent For Hardening By (Name)		Lark Forance		
6	Material Sent For Hardening On Date		27	11	24

### Inspected By (Sign) & Date

Ravi 27/11/24

Reviewed by (Engineer-CNC)

Manager-QA