

8662



# 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.		13412 ✓	34/50 ✓
2	Machined By		V.T.L. n/c Shop	Dry No. 6355
3	Pallet Die No.		13462 (4.0) n/c	
4	Die Category	Dr. No.	Extra wide	
5	Out Side Diameter	Dr. No.	620 n/c	Step length 19.5
6	Inside Diameter	Dr. No.	520.12 n/c	
7	Width of Pellet Die	Dr. No.	222 n/c	
8	Grooves as per Drawing	Dr. No.	13x8x5 n/c   13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 30/11/24

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					Counter = 6° Len = 31
2	External Relief Dia	4.5 n/c	outside (3-3)		inner		
3	External Relief Depth		20 n/c		16 n/c		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Porrace		
6	Material Sent For Hardening On Date		30	11	24		

### Inspected By (Sign) & Date

Ravi 30/11/24

*[Signature]*  
30/11/24

Reviewed by (Engineer-CNC)

Manager-QA