



# 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.		12752	80/80
2	Machined By		V.T.L. n/c Shop	Drill No. 1.3.0 = 798
3	Pallet Die No.		13813 (3.5) n/c	Reason
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	79.0 n/c, Step OD: 74.3.4 n/c	Tapper 1.3.0
6	Inside Diameter	Drg. No.	63.0.12 n/c	Step length 8.31
7	Width of Pellet Die	Drg. No.	265 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c   15x8x5 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		685 n/c	Tapping No. of Holes: 16
13	Tapping Hole Diameter		M2.2 Check by M2.2 Bolt	Both Side
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

Savi 28/11/24

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 - 1 Hole Closed (P)

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

Count per 60°  
Kaw = 42

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	—	—	No Relief			
3	External Relief Depth	—	—				
4	Inspection Done Before Hardening By (Name)		Savi				
5	Material Sent For Hardening By (Name)		Keshav				
6	Material Sent For Hardening On Date		28	11	24		

### Inspected By (Sign) & Date

Savi 28/11/24

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Reviewed by (Engineer-CNC)

Manager-QA