



# 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	Speciflcation	Observations	Remarks
1	Work Order No.		13036	20/20
2	Machined By		V.T.L N/c Shop	By No. 12.02.998
3	Pallet Die No.		13814(3.5)H4	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 H4 Step 00, 743.5 H4	Tapper 2.10°
6	Inside Diameter	Drg. No.	630.12 H4	Step length 23 H4
7	Width of Pellet Die	Drg. No.	265 H4	
8	Grooves as per Drawing	Drg. No.	15x8x5 H4 / 15x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of Holes 16 Both Side
12	Tapping PCD		685 H4	
13	Tapping Hole Diameter		H20. Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H4	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 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 - Hole Closed (A)

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

Counters 60  
Row 2 42

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia			No - Relief			
3	External Relief Depth						
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Keshav			
6	Material Sent For Hardening On Date		26	11	24		

### Inspected By (Sign) & Date

Ravi 28/11/24

Satyam 29/11/24

Reviewed by (Engineer-CNC)

Manager-QA