



# 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)

8729

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13305	45/45
3	Pallet Die No.		V.T.L. N/C Shop	Drg. No. 1.3.02-1186
4	Die Category	Drg. No.	13856(3.0) M4	Rev 2.00
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	4mm M4 Step OD = 3.89.4mm	Step length 1.0mm
7	Width of Pellet Die	Drg. No.	31.0.12 M4	
8	Grooves as per Drawing	Drg. No.	135 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	10x8x4.8 M4   10x8x4.9 M4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No. of holes = 8 Both Side
13	Tapping Hole Diameter		350 M4	
14	Tapping On Second Side	Half pitch of 1st side	0.31" = Check by 0.31" Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4mm Tapping Depth 18.6mm	
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 10/11/24

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 60°
2	External Relief Dia	8.5mm	Outside 2-2	Inner					Lower
3	External Relief Depth		4mm	Null					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		10	12	24				

### Inspected By (Sign) & Date

Ravi 10/11/24

Reviewed by (Engineer-CNC)

Manager-QA