



# 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.			
2	Machined By		13546 ✓	412/42 ✓
3	Pallet Die No.		V.T.L H/C Shop	Dr. No. 180-1112
4	Die Category	Drg. No.	13361 (B.5) H/C	Rev = 00 ✓
5	Out Side Diameter	Drg. No.	32 H	
6	Inside Diameter	Drg. No.	50.4 H, Step OD. 49.1 H	Step length 17 H
7	Width of Pellet Die	Drg. No.	42.0 H	
8	Grooves as per Drawing	Drg. No.	18.2 H	
9	Fitting Sizes on CNC Plate	Drg. No.	10x10x5 H / 10x10x5 H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	Tapping Hk of Holes: 8 Both Side
13	Tapping Hole Diameter		4.55 H ✓	
14	Tapping On Second Side	Half pitch of 1st side	0.3/4" Check by 0.3/4" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 19.3 H	Tapping Depth 17.6 H
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 11/12/24

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, Co
2	External Relief Dia	4.0 H	outside (2-2)		Inner			Row 2 27
3	External Relief Depth		4 H		Mill			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark For case
6	Material Sent For Hardening On Date			11	12	24		

### Inspected By (Sign) & Date

Ravi 11/12/24

Satish 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA