



# 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.		13584	36/50
2	Machined By		V.T.L. N/C Shop	Drg No. 1.2.0.452
3	Pallet Die No.		13186 (4.0) N/C	Recorol
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	52mm Step OD = 49mm	Step length 16.5
6	Inside Diameter	Drg. No.	42.012 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 mm / 10x8.5x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		455 mm	Tapping No. of Holes: 8 Both Side
13	Tapping Hole Diameter		0.314" = Check by 0.314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.3 mm Tapping Depth = 18.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 18/12/24

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 60° Rov = 24
2	External Relief Dia	4.5 mm	Outside (2-2)		Inner		
3	External Relief Depth		18 mm		14 mm		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Forracc
6	Material Sent For Hardening On Date		18	12	24		

### Inspected By (Sign) & Date

Ravi 18/12/24

Reviewed by (Engineer-CNC)

Manager-QA