



# 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.		13618	33/50
2	Machined By		V.T.G. H/O Shop	Dy No. 1.2.0.9980
3	Pallet Die No.		13649 (3.0) H/O	Rev 2.00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620 H/O	Step OD = 12°
6	Inside Diameter	Drg. No.	520.12 H/O	Step length = 18.5
7	Width of Pellet Die	Drg. No.	222 H/O	
8	Grooves as per Drawing	Drg. No.	1348 x 5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	1348 x 5 H/O	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		565 H/O	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/O	Tapping Depth 18.5 H/O
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 19/12/24

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

Counter = 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.5 H/O	Outside (3-3)		Inner					Rev 2.38
3	External Relief Depth		23 H/O		17 H/O					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			19	12	24				

### Inspected By (Sign) & Date

Ravi 19/12/24

Ravi 19/12/24

Reviewed by (Engineer-CNC)

Manager-QA