



# 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.		13624 ✓	36/50
2	Machined By		V.T.L H/c Shop	Dy. No. Lark 3970
3	Pallet Die No.		13654 (4.0) ✓	
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620H ✓ Step OD: 612H ✓	Step length: 19.5
6	Inside Diameter	Drg. No.	520.12H ✓	
7	Width of Pellet Die	Drg. No.	222H ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5H ✓ / 13x8x5H ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565H ✓	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		H20 + Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.3H ✓ Tapping Depth: 18.6H ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 20/12/24

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 - 2 Hole Closed

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

Counter = 603

1	Counter Sinking Depth & Finish	ok								Ravi 31
2	External Relief Dia	4.5H ✓	outside (2-3)		Inner					
3	External Relief Depth		18H ✓		14H ✓					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		20	12	24					

### Inspected By (Sign) & Date

Ravi 20/12/24

Reviewed by (Engineer-CNC)

Manager-QA