



# 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.		13767	27/40
2	Machined By		V.T.L n/c Shop	Drg No. 13767
3	Pallet Die No.		12448(3.0) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c	Step 002 Tappers 12°
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Hole 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.2 n/c	Tapping Depth = 16.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 24/12/24

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°
2	External Relief Dia	3.5 n/c	2-2	20 Side	Inner			Rev = 24
3	External Relief Depth		16 n/c		13 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Purchase
6	Material Sent For Hardening On Date		24	12	24			

Inspected By (Sign) & Date Ravi 24/12/24

Soti 24/12/24

Reviewed by (Engineer-CNC)

Manager-QA