



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13991	30/50
2	Machined By		V.T.L. M/c Shop	Drg No. 1.802998
3	Pallet Die No.		13826 (3.5) M/c	Rev 2.00
4	Die Category	Drg. No.	Perforator	
5	Out Side Diameter	Drg. No.	619.6 M/c	Step 002 Tabbers 12°
6	Inside Diameter	Drg. No.	520.12 M/c	Step length 12.5
7	Width of Pellet Die	Drg. No.	222 M/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 M/c   13x8x5 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No. of holes 12 Rota Side
12	Tapping PCD		565 M/c	
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 M/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 16/1/25

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 20°
2	External Relief Dia	4.0 M/c	outside (3-3)		Inner			Rev 2 35
3	External Relief Depth		24 M/c		20 M/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		16	1	25			

### Inspected By (Sign) & Date

Ravi 16/1/25

Reviewed by (Engineer-CNC)

Manager-QA