



# 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)

9080

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13901 ✓	34/40 ✓
2	Machined By		V. T. L n/c Shop	Dr. G. L. S. 21
3	Pallet Die No.		13242 (4.0) n/c	Rev 201 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Step 00, 499 n/c	Tapper 12
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 17 n/c
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 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 holes 8 Both side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		0234" 2 Check by 0234" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 n/c Tapping Depth 16.7 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 25/1/25

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 - 1 Hole Closed	

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	4.5 n/c	Outside (2-2)		Inner				Rev 20
3	External Relief Depth	/	10 n/c		6 n/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		25	1	25				

### Inspected By (Sign) & Date

Ravi 25/1/25

Reviewed by (Engineer-CNC)

Manager-QA