



# 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.		10229 ✓	40/50
2	Machined By		V.T.L. n/c Shop	Drg No. L.E.C. 2501
3	Pallet Die No.		9700 (3.5) n/c	Rev 201
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	699.8 n/c, Step 002 692.7 n/c	Tabber = 12
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c / 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		640 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 = 20.4 n/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 17/10/23

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok (Δ)
4	Defective Holes (If Any)		No - Hole Closed

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

1	Counter Sinking Depth & Finish	ok								Ravi 95
2	External Relief Dia	4.0 n/c	Outside (3-3)		Inner					
3	External Relief Depth	✓	17 n/c		10 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		17	10	23					

### Inspected By (Sign) & Date

Ravi 17/10/23

Reviewed by (Engineer-CNC)  
Sethi 17/10/23

Manager-QA