



# 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.		11000	32155
2	Machined By		V.T.L. H/a Shop	Dy. No. 6802407
3	Pallet Die No.		11571 (4.0) H/a	Rev. No.
4	Die Category	Drg. No.	M. Tumbo	
5	Out Side Diameter	Drg. No.	H/a Shop 00-692-8 H/a	Tapper 12"
6	Inside Diameter	Drg. No.	600.12 H/a	Step length 9.8
7	Width of Pellet Die	Drg. No.	292 H/a	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/a   12x8x7 H/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/a Shop	[ Tapping No of Holes = 12 ] [ Both Side ]
12	Tapping PCD		640 H/a	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.3 H/a	Tapping Depth 19 H/a
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/1/24

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

Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/a	outside (3-3)		Inner				
3	External Relief Depth		21 H/a		17 H/a				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Porrore				
6	Material Sent For Hardening On Date		17	1	24				

Inspected By (Sign) & Date

Ravi 17/1/24

Satyam 17/1/24

Reviewed by (Engineer-CNC)

Manager-QA