



# 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.		11397	30/50
2	Machined By		V.T.L. H/c Shop	Dy. No. L.E. 029980
3	Pallet Die No.		11723 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Endrawide	
5	Out Side Diameter	Drg. No.	62mm, Step 02 Tapper 12° Step length 18.5	
6	Inside Diameter	Drg. No.	52.014mm	
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 2/2 Both Side
12	Tapping PCD		56.5mm	
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 20.7mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 5/3/24

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	3.5mm	Outside (2.3)	Inner			Rev: 38
3	External Relief Depth		2.3mm	2mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Porrace
6	Material Sent For Hardening On Date		5	3	24		

**Inspected By (Sign) & Date**

Ravi 5/3/24

Sanyal 5/3/24

Reviewed by (Engineer-CNC)

Manager-QA