



# 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.		11636/	38/50/
2	Machined By		V.T.C. M/C Shop	Drg No. 18.02 799
3	Pallet Die No.		12055 (3.2) M/C	Rev. 2.00
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	620.1 M/C, Step 00, 620.1 M/C	Tap 2.12
6	Inside Diameter	Drg. No.	520.12 M/C	Step length 2.12
7	Width of Pellet Die	Drg. No.	222 M/C	Under cut 1.8 M/C
8	Grooves as per Drawing	Drg. No.	11x10x5 M/C   11x10x5 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 Both Side
12	Tapping PCD		565 M/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 20.8 M/C - Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/4/24

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 - 1 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 M/C	Outside (3.3)		Inner				
3	External Relief Depth		18 M/C		12 M/C				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 11/4/24

Reviewed by (Engineer-CNC)

Manager-QA