



# 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.		11842	38/50
2	Machined By		V.T.L. H/c Shop	Drill No. L-802-9980
3	Pallet Die No.		13122 (11.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Centerside	
5	Out Side Diameter	Drg. No.	620 H/c Step 00, Tapper, 12	Step length 18 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
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, 12 Back Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 20.8 H/c Tapping Depth, 19.8 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 7/5/24

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	4.3 H/c	Outside (3-3)		Inner				
3	External Relief Depth		16 H/c		12 H/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		7	5	24				

### Inspected By (Sign) & Date

Ravi 7/5/24

Sachin 7/5/24

Reviewed by (Engineer-CNC)

Manager-QA