



# 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.		12092 ✓	415/55 ✓
2	Machined By		V. T. L. N/C Shop	Dry Hole L.C. 14951
3	Pallet Die No.		12506 (8.0) mm	Recor ✓
4	Die Category	Drg. No.	Extrawide ✓	
5	Out Side Diameter	Drg. No.	630 mm Step 002 631.5 mm	Tapper 12 ✓
6	Inside Diameter	Drg. No.	520.12 mm	Step length 2.5 ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm   13x8x5 mm ✓	
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		565 mm	
14	Tapping On Second Side	Half pitch of 1st side	M202 Check by M20 Bolt ✓ ok	
15	Tapping Hole Depth		Drill Depth 20.6 mm	Tapping Depth 8.7 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 10/6/24

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 3.5 6.0 26 ✓
2	External Relief Dia	8.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		18 mm		10 mm ✓				
4	Inspection Done Before Hardening By (Name)				Ravi ✓				
5	Material Sent For Hardening By (Name)				Lark Pomace				
6	Material Sent For Hardening On Date		10	6	24				

### Inspected By (Sign) & Date

Ravi 10/6/24

Satyam 10/6/24

Reviewed by (Engineer-CNC)

Manager-QA