

# 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.			
2	Machined By		12222 ✓	30/40 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Digital Lark 9169 SS10 ✓
4	Die Category	Drg. No.	12085 (3.0) H/c ✓	
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	400 H/c Step OD, 395 H/c	Step length 145 ✓
7	Width of Pellet Die	Drg. No.	320.12 H/c ✓	
8	Grooves as per Drawing	Drg. No.	142 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	15.5 x 7 x 2 H/c   15.5 x 7 x 2 H/c ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		N/A Shop	Tapping No. of Holes = 8
13	Tapping Hole Diameter		355 H/c	Both Side
14	Tapping On Second Side	Half pitch of 1st side	MIG 2 Check by MIG Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 H/c	Tapping Depth 18
17	Visual Inspection Before Gun Drilling		yes OK	

### Inspected By (Sign) & Date

Ravi 3/2/24

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 Colours

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

1	Counter Sinking Depth & Finish	OK						Counter = 8
2	External Relief Dia	3.5 H/c	Outside 2.2 ✓	Inner				Ravi 20
3	External Relief Depth		10 H/c ✓	4 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		3	7	24			

### Inspected By (Sign) & Date

Ravi 3/2/24

Reviewed by (Engineer-CNC)

Manager-QA