

# 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.		12397	36/40
2	Machined By		V.T.L. n/c Shop	Dy. No. 12515-52
3	Pallet Die No.		11826 (B.6) n/c	Rep. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.		
6	Inside Diameter	Drg. No.	500 n/c Step 00, 498.3 n/c	Tabber 12"
7	Width of Pellet Die	Drg. No.	420.12 n/c	Step together
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12+8+3 n/c   12+8+3 n/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping No. of holes 8 Back side
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 18.3 n/c	Tapping Depth 165
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 8/7/24

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 80°
2	External Relief Dia	3.5 n/c	OO Side (2-2)	Inner					Rep 24
3	External Relief Depth		10 n/c	4 n/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		8	7	24				

### Inspected By (Sign) & Date

Ravi 8/7/24

Reviewed by (Engineer-CNC)

Manager-QA