



# 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.		9999	45/50	
2	Machined By		V.T.L. HLC Shop	Drg No. 1.3.9-406	
3	Pallet Die No.		10563 (3.2) H	Rev 2.00	
4	Die Category	Drg. No.	Ext 29 side		
5	Out Side Diameter	Drg. No.	6.20 H	Step 00. 6.23.9 H	
6	Inside Diameter	Drg. No.	5.20 H	Step length. 18 H	
7	Width of Pellet Die	Drg. No.	2.22 H	Under cut 2 H	
8	Grooves as per Drawing	Drg. No.	1.3 x 8 x 5 H	1.3 x 8 x 5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		HLC Shop	Tapping No of Holes. 12 Both Side	
12	Tapping PCD		565 H		
13	Tapping Hole Diameter		M2.2 Check by M2.0 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth. 20.4 H	Tapping Depth. 18.8	
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 4/8/23		
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		
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	ok		Rep. 37	
2	External Relief Dia	3.8 H	outside (3-3)	Inner	
3	External Relief Depth		12 H	5 H	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Romare		
6	Material Sent For Hardening On Date		4	8	23
Inspected By (Sign) & Date			Ravi 4/8/23		

Reviewed by (Engineer-CNC)

Manager-QA