



# 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.		9884	30/45/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1-3-02-420
3	Pallet Die No.		9710 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.7 n/c (1) Step 00, 691.8 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	600.12 n/c (1)	
7	Width of Pellet Die	Drg. No.	228 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 n/c / 12.5 x 8 x 7 n/c	
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		645 n/c	
13	Tapping Hole Diameter		M20 Chack by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22.4 n/c	Tapping Depth = 22.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Pass: 27/7/23

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	

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

1	Counter Sinking Depth & Finish	ok						Rev: 32
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c All Lines	5.0 n/c All Lines				
3	External Relief Depth		19 n/c	10 n/c				
4	Inspection Done Before Hardening By (Name)							Pass:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		27	7	23			

Inspected By (Sign) & Date

Pass: 27/7/23

Reviewed by (Engineer-CNC)

Manager-QA