



# 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

5921

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9984	32150
2	Machined By		V.T.L. n/c Shop	Drg No. L-3.0.85
3	Pallet Die No.		9694 (2.8) n/c	Rev 2.00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c Shop 00.693 n/c	Step length 19.
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	220 n/c	
8	Grooves as per Drawing	Drg. No.	9.5 x 10 x 6 n/c   9.5 x 10 x 6 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 Back side
12	Tapping PCD		645 n/c	
13	Tapping Hole Diameter		M20.2 check 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, 22.4 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 9/8/23

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

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 n/c	outside (3-3)		inner				
3	External Relief Depth	✓	2.3 n/c		1.8 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Forance				
6	Material Sent For Hardening On Date		9	8	23				

### Inspected By (Sign) & Date

Ravi 9/8/23

9/8/23

Reviewed by (Engineer-CNC)

Manager-QA