



# 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		12880	42/50
3	Pallet Die No.		V.T.L. H/C Shop	By Hand 18038
4	Die Category	Drg. No.	12773 (3.5) H/C	Revised
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	420 H/C	Step OD, 375 H/C
7	Width of Pellet Die	Drg. No.	320.12 H/C	Step length, 145
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		H/C Shop	Tapping No. of Holes, 2 Back Side
13	Tapping Hole Diameter		355 H/C	
14	Tapping On Second Side	Half pitch of 1st side	H162 Check by H16 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 14/9/24

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 Bo
2	External Relief Dia	4.0 H/C	008 Side (2-2)	Inner			Low, 18
3	External Relief Depth		15 H/C	8 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		14	9	24		

### Inspected By (Sign) & Date

Ravi 14/9/24

Reviewed by (Engineer-CNC)

Manager-QA