



# 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		10060	34/50
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. L.S.D. 633
4	Die Category	Drg. No.	9067 (4.0) H/H	Rev: 01
5	Out Side Diameter	Drg. No.	33310	
6	Inside Diameter	Drg. No.	620 H/H Step 002 623.6 H/H	Tabber 12
7	Width of Pellet Die	Drg. No.	520.12 H/H	Step length 20 H/H
8	Grooves as per Drawing	Drg. No.	180 H/H	Under cut 1.8 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/H 13x8x5 H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	[ Tapping No. of Holes 12 Both Side ]
13	Tapping Hole Diameter		505 H/H	
14	Tapping On Second Side	Half pitch of 1st side	NIG 2 Check by NIG Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 H/H Tapping Depth 18.8	
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 10/8/23

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	4.5 H/H	Outside (3-3)		Inner				Rev: 25
3	External Relief Depth		20 H/H		16 H/H				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			10	8	23			

Inspected By (Sign) & Date  
Ravi 10/8/23

Ravi 10/8/23

Reviewed by (Engineer-CNC)

Manager-QA