



# 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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10060	34/50
2	Machined By		V.T.L. n/c Shop	Drg No. L.S.D. 833
3	Pallet Die No.		9066 (4.0) NY	Rev. 2d
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 NY, Step OD = 623.9 NY	Step length 20 NY
6	Inside Diameter	Drg. No.	520.12 NY   520.14 (D)	Tapper = 12°
7	Width of Pellet Die	Drg. No.	186 NY	Undercut = 1.9 NY
8	Grooves as per Drawing	Drg. No.	13x8x5 NY   13x8x5 NY	
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 Bolt Side
12	Tapping PCD		565 NY	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 NY Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/8/23	
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		Ravi 25
2	External Relief Dia	4.5 NY	outside (3-3)	Inner
3	External Relief Depth		20 NY	18 NY
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11	23
Inspected By (Sign) & Date			Ravi 11/8/23	

Reviewed by (Engineer-CNC)

Manager-QA