



# 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.		13003	88/47
2	Machined By		N.T.L. n/c Shop	Drg No. 1.2.2.1895
3	Pallet Die No.		13151 (2.8) n/c	Row 200
4	Die Category	Drg. No.	2 side wide	
5	Out Side Diameter	Drg. No.	614 n/c Step 002 601.5 n/c	Tapping 12
6	Inside Diameter	Drg. No.	520.14 n/c	Step length 2.5
7	Width of Pellet Die	Drg. No.	222 n/c	Under cut 2.8 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 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		565 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date: Ravi 16/10/24

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 - 5 Hole Colused

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

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	2.3 n/c	outside (3-3)	inner				Row 239
3	External Relief Depth		22 n/c	19 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forncare					
6	Material Sent For Hardening On Date		16	10	24			

Inspected By (Sign) & Date: Ravi 16/10/24

Reviewed by (Engineer-CNC): Satya 16/10/24

Manager-QA