



# 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

5959

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10112	40/40
2	Machined By		V.T.L. H/c Shop	Drg No. I.E.C.E/15062
3	Pallet Die No.		9778 (5.0) H/H	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/H	Step OD 2 Tapped 2.12 Step length 2.8
6	Inside Diameter	Drg. No.	420.12 H/H	
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H   12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c. Shop	Tapping No of holes = 8 Both Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 H/H	Tapping Depth 16.8 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi: 17/8/23

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								Ravi-17
2	External Relief Dia	5.3 H/H	outside (2-2)		Inner					
3	External Relief Depth		4 H/H		Nil					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Ferrace					
6	Material Sent For Hardening On Date			17	8	23				

### Inspected By (Sign) & Date

Ravi: 17/8/23

Reviewed by (Engineer-CNC)

Manager-QA