



# 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.		13177	31/07
2	Machined By		N. T. L. H/O Shop	Dy. Insp. U. S. 15062
3	Pallet Die No.		11801 (2.8) H/O	Rev. Insp.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/O Shop 022 498.88	Tapped 12
6	Inside Diameter	Drg. No.	420.12 H/O	Shop length 18 H/O
7	Width of Pellet Die	Drg. No.	158 H/O	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping No. of Hole 8 Both Side
12	Tapping PCD		454 H/O	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.4 H/O Tapping Depth = 16.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Rawl 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

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

Counter 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.1 H/O	outside (2-2)		inner					
3	External Relief Depth		14 H/O		9 H/O					
4	Inspection Done Before Hardening By (Name)									Rawl
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		16	10	24					

### Inspected By (Sign) & Date

Rawl 16/10/24

16/10/24

Reviewed by (Engineer-CNC)

Manager-QA