



# 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.		13157	30/65
2	Machined By		V.T.C. H/C Shop	Drg No. (2.0)-017
3	Pallet Die No.		13024 (3.5) H/C	Recd. OK
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 H/C, Step 002, 792 H/C	Step length 20.5
6	Inside Diameter	Drg. No.	660.12 H/C	Under code 1 H/C
7	Width of Pellet Die	Drg. No.	384 H/C	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H/C   21.5 x 8 x 8 H/C	
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 = 12 Both Side
12	Tapping PCD		795 H/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 31.3 H/C	Tapping Dept. 29.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 9/11/24	2 Slot
1	As per programme no.		—	32.1 H/C width
2	Gun Drilling Work Completed On		—	8 H/C Deep
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
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		Counter 60° Law = 51
2	External Relief Dia	4.0 H/C	Outside (3-3)	Inner
3	External Relief Depth	✓	10 H/C	5 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		9 11 24	
Inspected By (Sign) & Date			Ravi 9/11/24	

Reviewed by (Engineer-CNC)

Manager-QA