



# 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.		10040	37/45
2	Machined By		V.T.L. H/C Shop	Dy. H. S.O. 364
3	Pallet Die No.		10763 (8.0) H/C	Rev 2.00
4	Die Category	Dr. No.	Junior	
5	Out Side Diameter	Dr. No.	400 H/C Step OD: 383 H/C	Step length: 11.4
6	Inside Diameter	Dr. No.	310.1 H/C	
7	Width of Pellet Die	Dr. No.	135 H/C	
8	Grooves as per Drawing	Dr. No.	12.1 x 8 = 3 H/C   12 x 8 = 3 H/C	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes: 2 Rota Side
12	Tapping PCD		350 H/C	
13	Tapping Hole Diameter		13/16" - Check by 13/16" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.6 H/C	Tapping Depth: 18.6 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Pass: 26/8/23

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							Row = 9
2	External Relief Dia	8.5 H/C	Outside (2-2)		Inner				
3	External Relief Depth		16 H/C		8 H/C				
4	Inspection Done Before Hardening By (Name)								Pass
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		26	8	23				

### Inspected By (Sign) & Date

Pass: 26/8/23

Reviewed by (Engineer-CNC)

Manager-QA