



# 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)

90/6

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13809	40/40
3	Pallet Die No.		V.T.L n/c Shop	Drg No. Lark 2310
4	Die Category	Drg. No.	13044 (5.0) n/c	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.6 n/c Step OD 2 490.5 n/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.12 n/c	
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c   12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of Holes = 8 Both Side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20x2 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.3 n/c	Tapping Depth = 16.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

### Inspected By (Sign) & Date

Ravi 17/1/25

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							Counter = 60° Row 2-17
2	External Relief Dia	5.5 n/c	Outside (2-2)		Inner				
3	External Relief Depth		5 n/c		Mill				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Purchase				
6	Material Sent For Hardening On Date		17	1	25				

### Inspected By (Sign) & Date

Ravi 17/1/25

Reviewed by (Engineer-CNC)

Manager-QA