



# 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.		10479	10/47
2	Machined By		V.T.L H/c Shop	Dy No. 1-EC-154/31
3	Pallet Die No.		10844 (3.0) H/c	Rev 2.00
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	614.4 H/c / Step OD 612.3 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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 10 Back Side
12	Tapping PCD		565 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 20.4 H/c Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Pasi 14/10/23

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							Pasi 38
2	External Relief Dia	3.5 H/c	Outside (3-3)		Inner				
3	External Relief Depth		13 H/c		7 H/c				
4	Inspection Done Before Hardening By (Name)								Pasi
5	Material Sent For Hardening By (Name)								Lark Portace
6	Material Sent For Hardening On Date		14	10	23				
Inspected By (Sign) & Date		Pasi 14/10/23							

Reviewed by (Engineer-CNC)

Manager-QA