



# 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.		10523 ✓	45/50 8252
2	Machined By		N.T.L. n/c Shop	Qty. n/c Lark 8310
3	Pallet Die No.		10531 (4.5) mm ✓	
4	Die Category	Drg. No.	33510 ✓	
5	Out Side Diameter	Drg. No.	620 mm ✓ Step 00: 612 mm ✓ Step length 19.4 ✓	
6	Inside Diameter	Drg. No.	520.12 mm ✓	
7	Width of Pellet Die	Drg. No.	136 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm   13x8x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK ✓	
11	Tapping Operator		n/c Shop	Tapping No. of Holes - 12 Bottom Side
12	Tapping PCD		565 mm ✓	
13	Tapping Hole Diameter		M20: Check by M2 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 23.7 ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK ✓	

**Inspected By (Sign) & Date**

Ravi 23/10/23

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							Ravi 23
2	External Relief Dia	5.0 mm ✓	Outside (3-3)		Inner				
3	External Relief Depth		9 mm ✓		5 mm ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forname
6	Material Sent For Hardening On Date		23	10	23				

**Inspected By (Sign) & Date**

Ravi 23/10/23

Reviewed by (Engineer-CNC)

Manager-QA