



# 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.		9753	50/50
2	Machined By		V.T.L. H/c Shop	Drg No. 18.0-81
3	Pallet Die No.		9054 (G.O) ✓	Rev = 00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	620mm ✓	Step 00 = 624mm ✓
6	Inside Diameter	Drg. No.	520.12mm ✓	Tapper 12°
7	Width of Pellet Die	Drg. No.	186mm ✓	Step length 14mm ✓
8	Grooves as per Drawing	Drg. No.	9x10x3mm ✓	Under cut 2 diam ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm ✓	Tapping No of Holes 18 Both Side
13	Tapping Hole Diameter		116 - Check by HIC Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 23.4mm ✓	Tapping Depth 21.7mm ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 28/6/23

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							
2	External Relief Dia	6.3mm ✓	Outside (3-3)		Inner				Row = 18
3	External Relief Depth		4mm ✓		Nil				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		28	6	23				

### Inspected By (Sign) & Date

Ravi 28/6/23

Reviewed by (Engineer-CNC)

Manager-QA