



# 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

6371

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10411	32/40/109
2	Machined By		V.T.L. N/C Shop	Dry Hole Lark 8870
3	Pallet Die No.		11201 (4.0) N/C	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400.1 N/C Step 00 = 395 N/C	Step length = 4.5
6	Inside Diameter	Drg. No.	320.12 N/C	
7	Width of Pellet Die	Drg. No.	14.2 N/C	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 N/C   15.5 x 7 x 2 N/C	
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 = 8 Both Side
12	Tapping PCD		355 N/C	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21 N/C Tapping Depth = 19 N/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/7/23

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 21/7/23
2	External Relief Dia	4.5 N/C	Outside (2-2)		Inner				
3	External Relief Depth		12 N/C		8 N/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forge
6	Material Sent For Hardening On Date		2	11	23				

Inspected By (Sign) & Date

Ravi 21/7/23

Reviewed by (Engineer-CNC)

Manager-QA