



# 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

S.No.	Check Parameter	Specification	Observations	Remarks	
1	Work Order No.		10548 / 10458	410/50	
2	Machined By		V.T.L. n/c Shop	Drg No. = L.S.O. 695	
3	Pallet Die No.		10984 (5.0) n/c	Rev. 2.00	
4	Die Category	Drg. No.	Junior	✓	
5	Out Side Diameter	Drg. No.	415 n/c Step 00. 389 n/c	Step length = 9.5	
6	Inside Diameter	Drg. No.	315.12 n/c		
7	Width of Pellet Die	Drg. No.	145.1 n/c		
8	Grooves as per Drawing	Drg. No.	15x8x3 n/c   15x8x3 n/c		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		n/c Shop	Tapping dia of holes = 8 Both Side	
12	Tapping PCD		355 n/c / 362 n/c		
13	Tapping Hole Diameter		φ 9/16" Check by 0.01" Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth = 17 n/c / 21.5 n/c	Tapping Depth = 15 n/c / 19 n/c	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 6/11/23		
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		
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	ok		Low = 14	
2	External Relief Dia	5.5 n/c	Outside (2-2)	Inner	
3	External Relief Depth	✓	15 n/c	10 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Fornace		
6	Material Sent For Hardening On Date		6	11	23
Inspected By (Sign) & Date			Ravi 6/11/23		

Reviewed by (Engineer-CNC)

Manager-QA