



# 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.		10485	49/49
2	Machined By		V.T.L. n/c Shop	Dry No. L.S.O. 873
3	Pallet Die No.		10918 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	389 n/c Step 002 383 n/c	Step length 9.5
6	Inside Diameter	Drg. No.	305.12 n/c	
7	Width of Pellet Die	Drg. No.	185 n/c	
8	Grooves as per Drawing	Drg. No.	6.5 x 6 x 4.5 n/c   6.5 x 6 x 4.5 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		350 n/c	
13	Tapping Hole Diameter		1/2" = Check by 1/2" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 16.0 n/c Tapping Depth 13.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/11/23

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok (A)
4	Defective Holes (If Any)		No. = 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Len = 16
2	External Relief Dia	4.3 n/c	Outside (2-2)		Inner				
3	External Relief Depth		4 n/c		Mill				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Forance				
6	Material Sent For Hardening On Date		4	11	23				
Inspected By (Sign) & Date				Ravi 4/11/23					

Reviewed by (Engineer-CNC)

Manager-QA