



# 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.		10474	47/50
2	Machined By		V.T.L. n/c Shop	Drg. no. I.S.O. 344
3	Pallet Die No.		8827 (3.0) H-H	Recess CD
4	Die Category	Drg. No.	H-JE10	
5	Out Side Diameter	Drg. No.	700 H-H Step CD, 692 H-H	Step length, 19.5
6	Inside Diameter	Drg. No.	600.12 H-H	
7	Width of Pellet Die	Drg. No.	265 H-H	
8	Grooves as per Drawing	Drg. No.	15x8x7 H-H / 15x8x7 H-H	
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 = 16 Both Side
12	Tapping PCD		640 H-H	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.5 H-H	Tapping Depth = 18.8 H-H
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 - 3 Hole Colused (M)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Row 2-47
2	External Relief Dia	3.5 H-H	outside (3-3)	Inner
3	External Relief Depth		9 H-H	3 H-H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6	11 23
Inspected By (Sign) & Date			Ravi 6/11/23	

Reviewed by (Engineer-CNC)

Manager-QA