



# 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.		10532	27/55
2	Machined By		V. T. L. n/c Shop	Drg. No. 1-S.D. 594
3	Pallet Die No.		11411 (4.5) n/c	Rev 2.00
4	Die Category	Drg. No.	590	
5	Out Side Diameter	Drg. No.	530 n/c Step 00, 491 n/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	104803 n/c   104803 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		454 n/c	
13	Tapping Hole Diameter		031/4" - Check by 031/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 n/c Tapping Depth: 16.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/11/23	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Row = 23
2	External Relief Dia	5.5 n/c	Outside (2-2)	Inner
3	External Relief Depth		32 n/c	28 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Parmar	
6	Material Sent For Hardening On Date		21	23
Inspected By (Sign) & Date			Ravi 21/11/23	

Reviewed by (Engineer-CNC)

Manager-QA