



# 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.		10713	40/50/8355
2	Machined By		V. T. G. H/c Shop	Dy. H/c Lark SS10
3	Pallet Die No.		11081(3.2) H/H	
4	Die Category	Drg. No.	Embarraside	
5	Out Side Diameter	Drg. No.	620H4 Step 00, 612H4	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/H	
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 12 Batu Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 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 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								Ravi 21/11/23
2	External Relief Dia	3.5 H/H	outside (3-3)		Inner					
3	External Relief Depth		16 H/H		10 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			21	11	23				

Inspected By (Sign) & Date

Ravi 21/11/23

Reviewed by (Engineer-CNC)

Manager-QA