



# 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.		10737	36/50, 6355	
2	Machined By		V.T.L. H/C Shop	Drg No. Lark 13570	
3	Pallet Die No.		11085 (3.0) H/C		
4	Die Category	Drg. No.	Extraxide		
5	Out Side Diameter	Drg. No.	620 H/C, Step OD 2.612 H/C	Step length 19.5	
6	Inside Diameter	Drg. No.	520.12 H/C		
7	Width of Pellet Die	Drg. No.	222 H/C		
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C   13x8x5 H/C		
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 Both Side	
12	Tapping PCD		565 H/C		
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 20.4 H/C	Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ravi 23/11/23		
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		Rev: 38	
2	External Relief Dia	3.3 H/C	Outside (3-3)	Inner	
3	External Relief Depth		20 H/C	14 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		23	11	23
Inspected By (Sign) & Date			Ravi 23/11/23		

Reviewed by (Engineer-CNC)  
SJS  
23/11/23

Manager-QA