



# 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.		10580	60/60
2	Machined By		V.T.L n/c Shop	Drg.No: LSD 732
3	Pallet Die No.		10293 (10.0) n/c	REV 00.
4	Die Category	Drg. No.	882	
5	Out Side Diameter	Drg. No.	540 n/c / 530.7 n/c Shop	532 n/c / 463 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	Slot Length 15 n/c
7	Width of Pellet Die	Drg. No.	190.8 n/c	11 n/c
8	Grooves as per Drawing	Drg. No.	40x8x7.5 n/c / 12.5x8x7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping n/c of Holes 8
11	Tapping Operator		n/c Shop	
12	Tapping PCD		480 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 5mm Ind Side One Slot	
15	Tapping Hole Depth		Drill Depth 95.8 n/c	Tapping Depth 94 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 25/11/23	1 slot 28 n/c width 11.5 n/c Depth
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. 8
2	External Relief Dia	_____	No Relief	
3	External Relief Depth	_____	_____	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25 11 23	
Inspected By (Sign) & Date			Ravi 25/11/23	

Reviewed by (Engineer-CNC)  
Sahil 25/11/23

Manager-QA