



# 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.		10772	35/40 ✓
2	Machined By		V. T. L. H/C Shop	Drg No. 18.0. 365
3	Pallet Die No.		11124 (4.0) H/H	Rev 2-00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 H/H Step 002 383.3 H/H Step length 11.1	
6	Inside Diameter	Drg. No.	310.12 H/H ✓	
7	Width of Pellet Die	Drg. No.	135 H/H ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H   12x8x3 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: 2 Back Side
12	Tapping PCD		350 H/H / 349.9 H/H	
13	Tapping Hole Diameter		M3/4" - Check by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.3 H/H Tapping Depth = 19.2 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 8/12/23

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						Loop 16
2	External Relief Dia	4.5 H/H	Outside (2-2)		Inner			
3	External Relief Depth		9 H/H		5 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		8	12	23			
Inspected By (Sign) & Date		Ravi 8/12/23						

Reviewed by (Engineer-CNC)

Manager-QA