



# 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.		10733/	29/40/
2	Machined By		V. T. I. n/c Shop	Drg No. I.S.O. 653
3	Pallet Die No.		11170 (3.2) n/c	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 n/c	Step 002 399.7 n/c Step length 9.5
6	Inside Diameter	Drg. No.	315.12 n/c	
7	Width of Pellet Die	Drg. No.	146 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x3 n/c   15x8x3 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		355.9 n/c	
13	Tapping Hole Diameter		ø3.0 Check by ø3.0 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 29.7 n/c Tapping Depth = 29.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/12/23

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	Approved By Mr. Foranjeet Saxi
4	Defective Holes (If Any)		No - 61 Hole Closed	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 n/c	Outside (2.2)		Inner				
3	External Relief Depth		14 n/c		11 n/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		14	12	23				
Inspected By (Sign) & Date		Ravi 14/12/23							

Reviewed by (Engineer-CNC)

Manager-QA