



# 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)

6637

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10908/	40/40
2	Machined By		V.T.C. H/C Shop	Dy. H.C. Lark 95
3	Pallet Die No.		10734 (4.0) H/C	310
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C, Step OD = 491 H/C	Step length = 17.5
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C   12 x 8 x 3 H/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 @ Back Side
12	Tapping PCD		454 H/C   453.9 H/C	
13	Tapping Hole Diameter		M22 Check by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 19.1 H/C   Tapping Depth = 17.1 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 19/12/23

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								Ravi 20
2	External Relief Dia	4.5 H/C	Outside (2-2)		Inner					
3	External Relief Depth		4 H/C		Nil					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		19	12	23					
Inspected By (Sign) & Date		Ravi 19/12/23								

Reviewed by (Engineer-CNC)

Manager-QA