



# 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.		10918	30/4/20
2	Machined By		V.T.L. H/A Shop	Drg No. last 310
3	Pallet Die No.		11257 (4.0) H/A	
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	620 H/A Step 00, 612 H/A	Step length 19.5
6	Inside Diameter	Drg. No.	520.14 H/A	
7	Width of Pellet Die	Drg. No.	222 H/A	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/A   13x8x5 H/A	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/A Shop	Tapping No of holes: 12 Back side
12	Tapping PCD		565 H/A	
13	Tapping Hole Diameter		H2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 21 H/A	Tapping Depth: 18.9 H/A
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 23/12/23

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					Counter = 60
2	External Relief Dia	4.5 H/A   5.0 H/A	4.5 H/A All Rows	5.0 H/A All Rows			Ravi 23/12/23
3	External Relief Depth		20 H/A	8 H/A			
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	12	23		

### Inspected By (Sign) & Date

Ravi 23/12/23

Reviewed by (Engineer-CNC)

Manager-QA