



# 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.		10998	40/45
2	Machined By		V.T.L. n/c Shop	Drg No. 1-30-904
3	Pallet Die No.		11143(3-0) n/c	Rev.
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	510 n/c	Step 00, 498.33 Tapper = 12°
6	Inside Diameter	Drg. No.	420.12 n/c	Step length, 18 n/c
7	Width of Pellet Die	Drg. No.	188 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.8 n/c	Tapping Depth = 12.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/1/24

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

	Counter	Go	Pass	30
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	3.5 n/c	Outside (2-2)	Inner
3	External Relief Depth		11 n/c	5 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		4	1 24

### Inspected By (Sign) & Date

Ravi 4/1/24

Satish 4/1/24

Inspected by (Engineer-CNC)

Manager-QA