



# 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.		11085	35/50
2	Machined By		V.T.C. H/C Shop	Drg. No. L.E.C. 9780
3	Pallet Die No.		11251 (4.0) H/C	
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	82mm, Step 00, Tappes	Step length 18.5
6	Inside Diameter	Drg. No.	52.12 H/C	
7	Width of Pellet Die	Drg. No.	92.2 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping dia of Holes - 12 Back Side
12	Tapping PCD		50.5 H/C	
13	Tapping Hole Diameter		112 - Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.5 H/C Tapping Depth 19 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Pavi 12/1/24	
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	
<b>Note : Mark the defective holes/ Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter 60° Rov 31
2	External Relief Dia	4.5 H/C	outside (2.3)	inner
3	External Relief Depth		19 H/C	15 H/C
4	Inspection Done Before Hardening By (Name)		Pavi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		13	1 24
Inspected By (Sign) & Date			Pavi 13/1/24	

Reviewed by (Engineer-CNC)

Manager-QA