



# 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)

690.7

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11172	40/40
2	Machined By		V.T.L H/c Shop	Drg No. 13.02 881
3	Pallet Die No.		11680 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	SEK	
5	Out Side Diameter	Drg. No.	500 H/c	
6	Inside Diameter	Drg. No.	Step OD, 490.7 H/c	Step length 18.4
7	Width of Pellet Die	Drg. No.	420.12 H/c	
8	Grooves as per Drawing	Drg. No.	172.8 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x5 H/c   12x10x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No of holes, 8 Both side
13	Tapping Hole Diameter		4.55 H/c	
14	Tapping On Second Side	Half pitch of 1st side	0.214" 2 Check by 0.214" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth, 21.4 H/c	Tapping Depth, 12.8
17	Visual Inspection Before Gun Drilling		Yes ok	

### Inspected By (Sign) & Date

Ravi 5/8/24

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 60°			
1	Counter Sinking Depth & Finish	OK			Ravi 27
2	External Relief Dia	3.5 H/c	Outside (2-2)	Inner	
3	External Relief Depth		6 H/c	Mill	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Porrace		
6	Material Sent For Hardening On Date		5	2	24
Inspected By (Sign) & Date		Ravi 5/8/24			

Reviewed by (Engineer-CNC)

Manager-QA