



# 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.		11314	46/50, 8355
2	Machined By		V.T.L. n/c Shop	Dry Hole, last 8319
3	Pallet Die No.		11625 (4.0) n/c	
4	Die Category	Drg. No.	4rd side	
5	Out Side Diameter	Drg. No.	620.2 n/c Step 00 = 612 n/c	Step length = 19.4
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 n/c / 13 x 8 x 5 n/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 = 12 Both Side
12	Tapping PCD		565 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 = 21 n/c	Tapping Depth = 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/8/24

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 26/8/24
2	External Relief Dia	4.5 n/c	outside (3-3)		Inner			
3	External Relief Depth		10 n/c		4 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Romace
6	Material Sent For Hardening On Date		26	2	24			

Inspected By (Sign) & Date

Ravi 26/8/24

Reviewed by (Engineer-CNC)

Manager-QA