



# 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.		10222	40/40
2	Machined By		V. T. L. H/C Shop	Drg No. 1.85215062
3	Pallet Die No.		10679 (5.0) H/C	Rev 2.0
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C	Step 0024983 Tapper - 12° Step length 18
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H. of holes 8. Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 H/C	Tapping Depth = 16.8 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 22/7/24

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							
2	External Relief Dia	5.5 H/C	outside (2-2)		Inner				
3	External Relief Depth		5 H/C		Nil				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		22	2	24				

### Inspected By (Sign) & Date

Ravi 22/7/24

Sats 27/7/24

Reviewed by (Engineer-CNC)

Manager-QA