



# 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

7037

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11343 to 11446	30/4/12
3	Pallet Die No.		N.T.L. n/c Shop	Dy. Insp. L.E.C. (1543)
4	Die Category	Drg. No.	11628 (3.0) n/c	Rev. 2.0
5	Out Side Diameter	Drg. No.	Extrawide	
6	Inside Diameter	Drg. No.	614 n/c / Step OD: 612 n/c	Step length 19.4
7	Width of Pellet Die	Drg. No.	52.12 n/c	
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c   13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping n/c of Holes all Both side
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	142.0 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 81.4 n/c Tapping Depth = 18.8	
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Rasi 11/3/24

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

1	Counter Sinking Depth & Finish	ok						Count are 600
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner			Rev. 38
3	External Relief Depth		20 n/c		17 n/c			
4	Inspection Done Before Hardening By (Name)							Rasi
5	Material Sent For Hardening By (Name)							Lark Roxace
6	Material Sent For Hardening On Date		1	3	24			

### Inspected By (Sign) & Date

Rasi 11/3/24

Reviewed by (Engineer-CNC)

Manager-QA