



# 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)

7080

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11431	29/50
2	Machined By		V.T.L. n/c Shop	Drg No. Lark 510
3	Pallet Die No.		11399 (3.2) n/c	
4	Die Category	Drg. No.	SSS TO	
5	Out Side Diameter	Drg. No.	620mm Step OD 2 G10 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c   13x8x5 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 Rote Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 21 n/c Tapping Depth - 18.2 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 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							Counter 60 Cap 29
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		24 n/c		21 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		11	3	24				

### Inspected By (Sign) & Date

Ravi 11/3/24

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Reviewed by (Engineer-CNC)

Manager-QA