



# 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.		11354/	55/60
2	Machined By		V.T.L. n/c Shop	Dy No. L.S.O. 494
3	Pallet Die No.		10205 (10.0) n/c	Revol
4	Die Category	Drg. No.	SSS10	
5	Out Side Diameter	Drg. No.	640 n/c / Step 00, 623.9 n/c	Tabber 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c   13x8x3 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, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 n/c, Tapping Depth 18.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/3/24

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°	
2	External Relief Dia	10.15 n/c	Outside (3-3)	Inner			Rev = 10°	
3	External Relief Depth		10 n/c	5 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		16	3	24			
Inspected By (Sign) & Date		Ravi 16/3/24						

Inspected By (Sign) & Date

Ravi 16/3/24

Reviewed by (Engineer-CNC)

Manager-QA