



# 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.		11480	45/50
2	Machined By		V.T.C. H/c Shop	Drg. No. Lark 8355
3	Pallet Die No.		11897 (3.5) H/c	8310
4	Die Category	Drg. No.	Ext. inside	
5	Out Side Diameter	Drg. No.	619.8 H/c (A) Sdrp 002 611.8 H/c (A)	Sdrplengte 19.4
6	Inside Diameter	Drg. No.	590.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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/c of Holes 12 Both side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H/c - Check by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.7 H/c	Tapping Depth 18.8 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Rasi 10/8/24

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

1	Counter Sinking Depth & Finish	OK						Counter 60°
2	External Relief Dia	3.8 H/c	Outside (3-3)		Inner			Row 2 35
3	External Relief Depth		12 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							Rasi
5	Material Sent For Hardening By (Name)							Lark Ferrace
6	Material Sent For Hardening On Date		16	3	24			

### Inspected By (Sign) & Date

Rasi 10/8/24

Reviewed by (Engineer-CNC)

Manager-QA