



# 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.		11453 ✓	50/55 ✓
2	Machined By		V.T.L H/c Shop	Drg No. L&C 14924
3	Pallet Die No.		11942 (6.0) H/c	Rev. 00 ✓
4	Die Category	Drg. No.	Endsaw side	
5	Out Side Diameter	Drg. No.	630 H/c	Step 002 612 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 19.5
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 Ho of holes = 12 Botu side
12	Tapping PCD		505 H/c	
13	Tapping Hole Diameter		M20, Check by M20 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 18/3/24

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 Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H/c	outside (3.3)		inner				
3	External Relief Depth		1 H/c		5 H/c				
4	Inspection Done Before Hardening By (Name)				Rasi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		18	3	24				

Inspected By (Sign) & Date Rasi 18/3/24

Reviewed by (Engineer-CNC)

Manager-QA