



# 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.		11442	48/50
2	Machined By		V.T.L n/c Shop	Drg No. 13.0-18
3	Pallet Die No.		11054(G.O) n/c	Rev. 02
4	Die Category	Drg. No.	SRD	
5	Out Side Diameter	Drg. No.	520 n/c, Step OD = 491 n/c	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	182.2 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c   12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of 4-les. 8 Both Side
12	Tapping PCD		454 n/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 = 19 n/c	Tapping Depth = 17.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/8/24	
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° Ravi 18
2	External Relief Dia	0.3 n/c	outside (2-2)	Inner
3	External Relief Depth		14 n/c	8 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		18	3 24
Inspected By (Sign) & Date			Ravi 18/8/24	

Reviewed by (Engineer-CNC)

Manager-QA