



# 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.		11548	Uol/42
2	Machined By		V. Til w/c Shop	Drg No 1-20-15431
3	Pallet Die No.		11970 (3.0) mm	Revised
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	61444 - Step OD = 612 mm, Step length 9.4	
6	Inside Diameter	Drg. No.	520.12 mm / 520.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
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 H/c, 12 R-L Side
12	Tapping PCD		505 mm	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/3/24

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

Count as per

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		13 mm		7 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		23	3	24				

Inspected By (Sign) & Date

Ravi 23/3/24

Reviewed by (Engineer-CNC)

Manager-QA