



# 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.			
2	Machined By		11441	
3	Pallet Die No.		V.T.L. n/c Shop	39/50
4	Die Category	Drg. No.	11726 (3.0) n/c	Dy No. 1-9.0-980
5	Out Side Diameter	Drg. No.	Extra side	Reo. 00
6	Inside Diameter	Drg. No.	620 n/c	
7	Width of Pellet Die	Drg. No.	520.4 n/c	Step 12" Step length 18.
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8=5 n/c   13x8=5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		50.5 n/c	Tapping Holes of Holes 12 Back Side
14	Tapping On Second Side	Half pitch of 1st side	4202 Check by 400 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Repts. 20.7 n/c	Tapping Depth = 18.2 n/c
17	Visual Inspection Before Gun Drilling		yes	

### Inspected By (Sign) & Date

1	As per programme no.			Ravi 27/3/24
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		ok
4	Defective Holes (If Any)			No - 2 Hole Colours ok

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	3.3 n/c	60 Side (3.3)		Inner		Reo. 38
3	External Relief Depth		17 n/c		11 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		27	3	24		

### Inspected By (Sign) & Date

				Ravi 27/3/24
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Satyam 27/3/24

Reviewed by (Engineer-CNC)

Manager-QA