



# 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.		11571	38/50
2	Machined By		V.T.L. H/C Shop	8752 8810
3	Pallet Die No.		11402 (4.0) H	
4	Die Category	Drg. No.	58370	
5	Out Side Diameter	Drg. No.	6.20 H	Step length 19.4
6	Inside Diameter	Drg. No.	5.20.12 H	
7	Width of Pellet Die	Drg. No.	1.86 H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H / 13x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.8 H Tapping Depth: 18.8 H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 29/3/24

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  
Low: 25

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 H	Outside (2-3)	Inner			
3	External Relief Depth		16 H	12 H			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		29	3	24		

### Inspected By (Sign) & Date

Ravi 29/3/24

Reviewed by (Engineer-CNC)

Manager-QA