



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

7289

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11674	
2	Machined By		V.T.L. n/c Shop	50/50
3	Pallet Die No.		12259 (8.0) n/c	Drill No. 1202/376
4	Die Category	Drg. No.	Senior	Rev. 20
5	Out Side Diameter	Drg. No.	520 n/c, Step 00. 49 n/c	Step length 13.4
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	158 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 No. of holes 2 Back 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 18.8 n/c	Tapping Depth 17 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 10/4/24

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 10
2	External Relief Dia	8.5 n/c	outside (2-2)	Inner			Rev 12
3	External Relief Depth		4 n/c	Mill			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		10	4	24		
Inspected By (Sign) & Date		Ravi 10/4/24					

Reviewed by (Engineer-CNC)

Manager-QA