



# 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

2318

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11721	36/40
2	Machined By		V.T.L. H/C Shop	Dy. No. 18.02881
3	Pallet Die No.		11698 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	582	
5	Out Side Diameter	Drg. No.	500 H/C Step OD = 490.7 H/C	Step length = 16.5
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	173 H/C	
8	Grooves as per Drawing	Drg. No.	12x10x5 H/C / 12x10x5 H/C	
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 = 8 Both Side
12	Tapping PCD		455 H/C	
13	Tapping Hole Diameter		0.34" - Check by 0.34" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 H/C Tapping Depth = 18.8 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/4/24

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 - 1 Hole Closed	

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 H/C	Outside (2.2)		Inner				Low = 27
3	External Relief Depth		10 H/C		4 H/C				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		15	4	24				

Inspected By (Sign) & Date

Ravi 15/4/24

Reviewed by (Engineer-CNC)

Manager-QA