



# 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.		11982	42/50
2	Machined By		V.T.L. H/c Shop	Dr. No. L.E.C. 1980
3	Pallet Die No.		12050 (4.0) H/c	Rev. 00
4	Die Category	Drg. No.	Ext. Inside	
5	Out Side Diameter	Drg. No.	620 H/c Step OD, Tapper 12° Step length 18	
6	Inside Diameter	Drg. No.	520.14 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c   13x8x5 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 12 Bolt Side
12	Tapping PCD		565 H/c	
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/c Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 7/5/24	
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		Counters 60 Ravi 31
2	External Relief Dia	4.3 H/c	Outside (3-3)	Inner
3	External Relief Depth		12 H/c	8 H/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		7	5 24
Inspected By (Sign) & Date			Ravi 7/5/24	

Reviewed by (Engineer-CNC)

Manager-QA