



# 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.		11792	37150
2	Machined By		V.T.L. H/C Shop	Dry No. 18.0.406
3	Pallet Die No.		12095 (3.5) H/C	Rev. 00
4	Die Category	Drg. No.	Ex-Outside	
5	Out Side Diameter	Drg. No.	620.11 H/C Step 00.2 620 H/C Step length 18 H/C	
6	Inside Diameter	Drg. No.	520.12 H/C	Tapper 12"
7	Width of Pellet Die	Drg. No.	222 H/C	Under note 2-
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 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M20. 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 9/5/24	
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 - 2 Hole Closed	
<b>Note :</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK	Counter: 60	
2	External Relief Dia	4.0 H/C	Outside (3.3)	Inner
3	External Relief Depth		17 H/C	13 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		9	5 24
Inspected By (Sign) & Date			Ravi 9/5/24	

Reviewed by (Engineer-CNC)

Manager-QA