



# 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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11888	40/55
2	Machined By		V.T.L. N/C Shop	Drilling No. 1.8.0.407
3	Pallet Die No.		12149 (6.0) N/C	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	Flange Step OD: 69.2-8 N/C	Tabber 12
6	Inside Diameter	Drg. No.	60.12 N/C	Step length 2.5 N/C
7	Width of Pellet Die	Drg. No.	22.2 N/C	
8	Grooves as per Drawing	Drg. No.	123.8 x 7 N/C / 11.7 x 8 x 7 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 12 Both Side
12	Tapping PCD		64.0 N/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 N/C	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 8/5/24

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					Counter Sink
2	External Relief Dia	6.5 N/C	Outside (3.3)		Inner		
3	External Relief Depth		2.1 N/C		1.5 N/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		8	5	24		

Inspected By (Sign) & Date

Ravi 8/5/24

Reviewed by (Engineer-CNC)

Manager-QA