



# 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.		12109	50/55
2	Machined By		V.T.L. H/c Shop	Dy. H/c L.S.G. 14924
3	Pallet Die No.		12469 (5.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Cast 29 side	
5	Out Side Diameter	Drg. No.	630 H/c Step 002 612 H/c Step length	19.5
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 H/c of Holes 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 10/6/24

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. 600
2	External Relief Dia	5.5 H/c	outside (3-3)		Inner				low side
3	External Relief Depth		10 H/c		5 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		10	6	24				

### Inspected By (Sign) & Date

Ravi 10/6/24

Satyam 10/6/24

Reviewed by (Engineer-CNC)

Manager-QA