



# 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.		12170	28/45
2	Machined By		V.T.G. n/c Shop	Dy No. 12.9.1070
3	Pallet Die No.		12240(4.0) n/c	Rev = 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 n/c, Step 002 386 n/c	Step length 11.5
6	Inside Diameter	Drg. No.	305.12 n/c / 304.12 n/c	
7	Width of Pellet Die	Drg. No.	144 n/c	
8	Grooves as per Drawing	Drg. No.	16x8x5 n/c / 16x8x5.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping N. of holes B. Both side
12	Tapping PCD		353 n/c	
13	Tapping Hole Diameter		M22 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	Tapping Depth 18.9 n/c
15	Tapping Hole Depth		Drill Depth 20.4 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 18/6/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		N=

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Count on 2 G's Row 216

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	4.5 n/c	Outside (2.2)	Inner		
3	External Relief Depth		21 n/c	17 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		18	6	24	

### Inspected By (Sign) & Date

Ravi 18/6/24

Satya 18/6/24

Reviewed by (Engineer-CNC)

Manager-QA