



# 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.		12187	30/06
2	Machined By		N.T.L. n/c Shop	Drg No. 1.S.D. 609
3	Pallet Die No.		12488(10.0) n/c	Rev: 01
4	Die Category	Drg. No.	N. Tomba n/c	
5	Out Side Diameter	Drg. No.	680.7 n/c, Step 602-693 n/c	Tapper 8°
6	Inside Diameter	Drg. No.	548.10 n/c	Step length 91 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c   32 x 7 x 8 n/c	(4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side Step Side side
11	Tapping Operator		n/c Shop	8 n/c Raab Side
12	Tapping PCD		219 n/c	Tapping No.
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of Hole = 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Bolt Side
15	Tapping Hole Depth		Drill Depth = 35 n/c	Tapping Depth = 32 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi 25/6/24

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 6° Row = 8
2	External Relief Dia	11.0 n/c	All Rows					
3	External Relief Depth		30 n/c					
4	Inspection Done Before Hardening By (Name)		Rasi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		25	6	24			

Inspected By (Sign) & Date

Rasi 25/6/24

Saty 25/6/24

Reviewed by (Engineer-CNC)

Manager-QA