



# 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.		12244	30/55/75
2	Machined By		V. T. L. H/c Shop	Drill No. 62.9.834
3	Pallet Die No.		12957(6.0)mm	Recessed
4	Die Category	Drg. No.	M72W	
5	Out Side Diameter	Drg. No.	7.02 mm, 3rd step OD, 7.77 mm / 7.78 mm	
6	Inside Diameter	Drg. No.	5.72.12 mm	6th step length 42 mm
7	Width of Pellet Die	Drg. No.	2.70 mm	Under cut = 27.5 mm
8	Grooves as per Drawing	Drg. No.	106x8x12 mm / 88x8x12 mm	
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 6
12	Tapping PCD		660 mm	
13	Tapping Hole Diameter		ø31.6" ± Check by ø31.6" Pin	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 2nd side one 31.6"	
15	Tapping Hole Depth		Drill Depth 35.3 mm	Tapping Depth 33
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 28/8/24

1	As per programme no.			1 Slot 39 mm width 28 mm Deep
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 8
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Rows	7.0 mm All Rows				
3	External Relief Depth		4.5 mm	2.0 mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		7	8	24			

### Inspected By (Sign) & Date

Ravi 28/8/24

Satyam 28/8/24

Reviewed by (Engineer-CNC)

Manager-QA