



# 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.		12879	415/50	
2	Machined By		V. T. L. H/c Shop	Dry Hole 1.2.0.10 969	
3	Pallet Die No.		13371 (4.0) H/c	Revol	
4	Die Category	Drg. No.	Yombo		
5	Out Side Diameter	Drg. No.	760 H/c Step OD = 792 H/c	Step length = 97 H/c	
6	Inside Diameter	Drg. No.	660.12 H/c	Under cut = 16 H/c	
7	Width of Pellet Die	Drg. No.	324 H/c		
8	Grooves as per Drawing	Drg. No.	21x8x10 H/c / 21x8x10 H/c		
9	Fitting Sizes on CNC Plate	Drg. No.	OK		
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		H/c Shop	Tapping No of Holes = 12 Both Side	
12	Tapping PCD		725 H/c		
13	Tapping Hole Diameter		M20 - Check by M20 Ball		
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth = 27.4 H/c	Tapping Depth = 25.5	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ravi 20/9/24	2 Slot 32.1 H/c width 9 H/c Deep Both Side	
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		
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	OK		Counter = 65 Rov = 48	
2	External Relief Dia	4.5 H/c	Outside (3-3)	Inner	
3	External Relief Depth		13 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		20	9	24
Inspected By (Sign) & Date			Ravi 20/9/24		

Reviewed by (Engineer-CNC)  
Sethi 20/9/24

Manager-QA