



# 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.		12830 ✓	410/66
2	Machined By		V. T. L. n/c Shop	Drilling 12.02.2013
3	Pallet Die No.		13329 (8.0) n/c ✓	Rev. 05
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 n/c ✓ Step OD: 699 n/c	Tapper = 3
6	Inside Diameter	Drg. No.	548.1 n/c ✓	Step length = 31 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	[ Face Side Step [ n/c Reck Both Side Tapping No of Holes: 4 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		MIG: Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 34.8 n/c	Tapping Depth: 32 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 20/9/24

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: 30 Rep: 10
2	External Relief Dia	9.0 n/c	All Rows					
3	External Relief Depth	✓	26 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		20	9	24			

### Inspected By (Sign) & Date

Ravi 20/9/24

*[Signature]*  
20/9/24

Reviewed by (Engineer-CNC)

Manager-QA