



# 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.		12912	30/66
2	Machined By		V.T.L. N/C Shop	Dry No. 1.B.D. 300
3	Pallet Die No.		12952 (G.O) N/C	Rev 05
4	Die Category	Drg. No.	N. Jumbo	to L.S.D-609 (Rev 02)
5	Out Side Diameter	Drg. No.	680.144 N/C	Tappet 2.8
6	Inside Diameter	Drg. No.	548.044	Step length 31 N/C
7	Width of Pellet Die	Drg. No.	19544	Undercuts 2.544
8	Grooves as per Drawing	Drg. No.	32x7x844	(4x8)44
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side
10	Drilling Area Surface Smoothness		ok	Step 2 N/C Deep
11	Tapping Operator		N/C Shop	Both Side
12	Tapping PCD		61944	Tapping N/C
13	Tapping Hole Diameter		NIS 2 Check by NIS Belt	of Hole 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 34.844	Tapping Depth 3044
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 21/9/24

1	As per programme no.			Final Size
2	Gun Drilling Work Completed On			Fitting Size
3	Hole Finish In Gun Drilling	Marked	ok	Dry No. 1.B.D
4	Defective Holes (If Any)		No	609 Rev 200

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

1	Counter Sinking Depth & Finish	ok					Counter, 30
2	External Relief Dia	7.044		All Rows			Pop 2 Id
3	External Relief Depth			3644			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Porrace			
6	Material Sent For Hardening On Date			21	9	24	

### Inspected By (Sign) & Date

Ravi 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA