



# 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.		12875	30/80
2	Machined By		V. T. L. n/c Shop	Drg. No. 63.02.750
3	Pallet Die No.		12073 (6.0) n/c	Rev. 02
4	Die Category	Drg. No.	Junbo	
5	Out Side Diameter	Drg. No.	730 n/c Step 0.2 732 n/c / 632 n/c	
6	Inside Diameter	Drg. No.	572.12 n/c	Step length 35 n/c
7	Width of Pellet Die	Drg. No.	219 n/c	Undercut 2.14 n/c
8	Grooves as per Drawing	Drg. No.	75 x 8 x 8 n/c   58 x 8 x 8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 6
12	Tapping PCD		650 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 1/2nd Side One	Bl. 1
15	Tapping Hole Depth		Drill Depth 40.4 n/c	Tapping Depth 38.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/9/24	1 SLOT 32.1 n/c width 19 n/c Depth Slot rework after hard
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 = 60 Row = 8
2	External Relief Dia	7.0 n/c	All Rows	
3	External Relief Depth		50 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		23 9 24	
Inspected By (Sign) & Date			Ravi 23/9/24	

Reviewed by (Engineer-CNC)  
Sathya 23/9/24

Manager-QA