



# 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.		13018	52/52
2	Machined By		V.T.G. H/c Shop	Drg No. 132, 1163
3	Pallet Die No.		12900 (8.0) H/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	413.9 H/c, Step OD: 388 H/c	Step heights 9.4
6	Inside Diameter	Drg. No.	310.12 H/c	
7	Width of Pellet Die	Drg. No.	146 H/c	
8	Grooves as per Drawing	Drg. No.	15x8x3 H/c   15x8x3 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 24 ] Baku Side
12	Tapping PCD		352 H/c	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 25.3 H/c	Tapping Depth: 23.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 16/10/24

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

Counters 60°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	8.5 H/c	Outside (2-2)		Inner					
3	External Relief Depth		5 H/c		Nil					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		16	10	24					

### Inspected By (Sign) & Date

Ravi 16/10/24

Satyam 16/10/24

Reviewed by (Engineer-CNC)

Manager-QA