



# 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.		13123	36/45
2	Machined By		V.T.L. H/c Shop	Py H/c 12.92 302
3	Pallet Die No.		13293(6.0) H/c	Rev: 00
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	510 H/c	Step OD: 491 H/c
6	Inside Diameter	Drg. No.	420.12 H/c	Step length: 18.5
7	Width of Pellet Die	Drg. No.	173 H/c	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 H/c / 10x8.5x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		455 H/c	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	Tapping No. of Holes: 8 Bolt Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.3 H/c	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi: 28/10/24

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

1	Counter Sinking Depth & Finish	OK						Counter: 60
2	External Relief Dia	6.5 H/c	Outside (2-2)		Inner			Rev: 17
3	External Relief Depth		15 H/c		9 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		28	10	24			

### Inspected By (Sign) & Date

Ravi: 28/10/24

Reviewed by (Engineer-CNC)

Manager-QA