



# 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.		13260 ✓	P8/66 ✓
2	Machined By		V.T.L M/c Shop	Dr. No - 30. fixed ✓
3	Pallet Die No.		13787 (6.0 mm) ✓	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1mm / Step od- 693mm	Step length- 31mm ✓
6	Inside Diameter	Drg. No.	546.1mm	Taper- 8° ✓
7	Width of Pellet Die	Drg. No.	195mm ✓	Undercut- 28mm ✓
8	Grooves as per Drawing	Drg. No.	3PX 7X 9mm / 3PX 7X 9mm (4X 8mm) ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes ? ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm ✓	- Both side ✓
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	(Face 4.5 X P) ✓
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth - 33mm Tapping depth - 31.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Jan 18/11/24

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

Counter-30°

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.0mm	All Rows				
3	External Relief Depth		38mm				
4	Inspection Done Before Hardening By (Name)	Sameer 17/11/24					
5	Material Sent For Hardening By (Name)	Lark Furnace					
6	Material Sent For Hardening On Date	16	11	24			

### Inspected By (Sign) & Date

Jan 18/11/24

Sameer 18/11/24  
Reviewed by (Engineer-CNC)

Manager-QA