

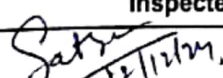
# Lark Engineering Company (India) Pvt. Ltd.

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.			27/66
2	Machined By		13391 ✓	
3	Pallet Die No.		V.T.L H/c Shop	Dy No. 13.0 = 230
4	Die Category	Dr. No.	13629 (6.0) H/c	Rev. 08
5	Out Side Diameter	Dr. No.	M. Jumbo	
6	Inside Diameter	Dr. No.	680.1 H/c, Step 02 = 693 H/c	Tapped 2
7	Width of Pellet Die	Dr. No.	546.12 H/c (Box = 548.12)	Step long the 2 H/c
8	Grooves as per Drawing	Dr. No.	195 H/c	Under cuts 2.3 H/c
9	Fitting Sizes on CNC Plate	Dr. No.	32 x 7 x 9.1 H/c / 32 x 7 x 9.1 H/c (4 x 8) H/c	
10	Drilling Area Surface Smoothness		OK	Face side Step
11	Tapping Operator		H/c Shop	2 H/c Deep Bolt
12	Tapping PCD		619 H/c	Side
13	Tapping Hole Diameter		OK	Tapping No of holes = 2
14	Tapping On Second Side	Half pitch of 1st side	MIG + Check by MIG Bolt	Bolt Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 33.3 H/c	Tapping Depth 31.5 H/c
17	Visual Inspection Before Gun Drilling		Yes	
Inspected By (Sign) & Date			Ravi 10/12/24	
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		Row = 12
2	External Relief Dia	7.0 H/c	All Rows	
3	External Relief Depth		39 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		18 12 24	
Inspected By (Sign) & Date			Ravi 10/12/24	

Reviewed by   
 Engineer-CNC

Manager-QA