



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8702

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.			
2	Machined By		13485 ✓	45/60 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Dynas 13.02.11
4	Die Category	Dr. No.	13801 (4.0) n/c	Rev 200
5	Out Side Diameter	Dr. No.	Jumbo	
6	Inside Diameter	Dr. No.	780 n/c, Step OD, 792 n/c	Step length = 29.5
7	Width of Pellet Die	Dr. No.	660.14 n/c	Undercut 8 n/c
8	Grooves as per Drawing	Dr. No.	324 n/c ✓	
9	Fitting Sizes on CNC Plate	Dr. No.	21.5 x 28 x 8 n/c   21.5 x 28 x 8 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping n/c of holes. 12 Both Side
13	Tapping Hole Diameter		785 n/c ✓	
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Bull ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 31.3 n/c Tapping Depth 29.5	
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 6/12/24

1	As per programme no.			2 Slot 32.1 n/c width 8 n/c Depth Both Side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 4 Hole Closed	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Count em = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 n/c ✓	Outside (3-3)		Inner				
3	External Relief Depth		23 n/c		15 n/c				
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Raynace					
6	Material Sent For Hardening On Date		3	12	24				

### Inspected By (Sign) & Date

Ravi 6/12/24

Sats 6/12/24

Reviewed by (Engineer-CNC)

Manager-QA