



# Lark Engineering Company (India) Pvt. Ltd.

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

8709

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		13491/	35/55/
3	Pallet Die No.		V.T.L. H/c Step	Dr. No. 18.9.2457
4	Die Category	Drg. No.	13290(3.3)H/	Rev. 2.00/
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	770H/ Step 00, 800H/	Step length 20H/
7	Width of Pellet Die	Drg. No.	66012 H/	Under cut 15H/
8	Grooves as per Drawing	Drg. No.	316 H/	
9	Fitting Sizes on CNC Plate	Drg. No.	20x8 & 7.5 H/ / 20x8 & 7.5 H/	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Step	Tapping H/c of Holes 12 Both Side
13	Tapping Hole Diameter		7.25H/	
14	Tapping On Second Side	Half pitch of 1st side	H/c Check by H/c Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 25.3H/ Tapping Depth 22.6	
17	Visual Inspection Before Gun Drilling		yes OK	

### Inspected By (Sign) & Date

Ravi 6/12/24

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 - 1 Hole Closed

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

Count etc 60  
Rev 2.43

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.3H/	outside (3.3)		Inner		
3	External Relief Depth		2.4H/		20H/		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date			6	12	24	
Inspected By (Sign) & Date		Ravi 6/12/24					

Reviewed by (Engineer-CNC)

Manager-QA