



# 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.		13511	33/4970
2	Machined By		V.T.L. n/c Shop	1 Day No. 12.92.277
3	Pallet Die No.		13347 (6-0) n/c	Rev. 103
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 n/c	Step 00. 697.7 n/c
6	Inside Diameter	Drg. No.	548.1 n/c	695.4 n/c
7	Width of Pellet Die	Drg. No.	915 n/c	Step length 28.5
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 n/c	Under cut = 1.3 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 10 x 8 n/c	(6 x 8)
10	Drilling Area Surface Smoothness		ok	Face side step 1 n/c Dark Bottom Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		618 n/c	Tapping No. of holes 2 Bottom Side
13	Tapping Hole Diameter		M16. Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 32 n/c Tapping Depth. 30 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 14/12/24

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

Count Len - 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 n/c	7.3 n/c	6.5 n/c	All Rows 2	37 n/c			
3	External Relief Depth			7.3 n/c	All Rows 2	22 n/c			
4	Inspection Done Before Hardening By (Name)					Ravi			
5	Material Sent For Hardening By (Name)					Lark Forcare			
6	Material Sent For Hardening On Date			14	12	24			

### Inspected By (Sign) & Date

Ravi 14/12/24

Reviewed by (Engineer-CNC)

Manager-QA