



# 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.			
2	Machined By		13309 ✓	48/67
3	Pallet Die No.		V.T.L. n/c Shop	55/67 ✓
4	Die Category	Drg. No.	13792 (12.0) n/c	Dry Hole L.S.D. 645
5	Out Side Diameter	Drg. No.	H. Jumbo	Rev. 02
6	Inside Diameter	Drg. No.	682 n/c → Step OD 2 893 n/c	Tapper 5°
7	Width of Pellet Die	Drg. No.	548.1 n/c	Step length 29 n/c
8	Grooves as per Drawing	Drg. No.	196 n/c	Under cut = 2.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	27x10x8 n/c / 27x10x8 n/c (2x8) n/c	
10	Drilling Area Surface Smoothness		ok	[ Face Side Step 1 n/c Rasp Back Side Tapping Hole of Holes, 2 Back Side ]
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		618 n/c	
14	Tapping On Second Side	Half pitch of 1st side	MFG 2 Check by M16 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 32.3 n/c	Tapping Depth: 30.5
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 11/12/24

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 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	13.0 n/c	1st Pad	2nd Pad				Row 2 G
3	External Relief Depth		19 n/c	12 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Rosnace					
6	Material Sent For Hardening On Date		11	12	24			

### Inspected By (Sign) & Date

Ravi 11/12/24

Saty 12/11/24  
Reviewed by (Engineer-CNC)

Manager-QA