



# 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.		13631	34/50
2	Machined By		V.T.L. H/c. Shop	Drill No. 1202419
3	Pallet Die No.		12872 (d.3) H/c	Rev 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c Step OD = 692 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/c / 12.5 x 8 x 7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c. Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		645 H/c	
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 22.3 H/c Tapping Depth = 20.5 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 18/12/24

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

1	Counter Sinking Depth & Finish	OK (A)					Counter = 60
2	External Relief Dia	3.2 H/c	Outside (3-3)	Inner			Row = 40
3	External Relief Depth		22 H/c	18 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 18/12/24

Jotsu 18/12/24

Reviewed by (Engineer-CNC)

Manager-QA