



# 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.		13106	48/66
2	Machined By		V.T.L. H/c Shop	55/66
3	Pallet Die No.		13344 (8.0) H/c	Drg No. 13.0.1095
4	Die Category	Drg. No.	M. Jumbo	Rev 2.00
5	Out Side Diameter	Drg. No.	680 H/c Step 0.02	692.5 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	548.12
7	Width of Pellet Die	Drg. No.	215 H/c	Step length 28 H/c
8	Grooves as per Drawing	Drg. No.	30.5 x 6 x 8 H/c	30.5 x 6 x 8 H/c (6 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side 3rd H/c
11	Tapping Operator		H/c Shop	Deep Both Side
12	Tapping PCD		680 H/c	Tapping No. of Holes. 2
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 32.3 H/c	Tapping Depth. 30.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 31/12/24

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 Sinking Depth & Finish	External Relief Dia	External Relief Depth	Inspection Done Before Hardening By (Name)	Material Sent For Hardening By (Name)	Material Sent For Hardening On Date
1	ok	9.0 H/c	18 H/c	Ravi	Lark Furnace	3 12 24
2						
3						
4						
5						
6						

### Inspected By (Sign) & Date

Ravi 31/12/24

Reviewed by (Engineer-CNC)

Manager-QA