



# 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.		13651	33/50	
2	Machined By		V. T. L. H/O Shop	Dy. No. 18.0.450	
3	Pallet Die No.		13157 (B.O) H/H	Rev. 00	
4	Die Category	Dr. No.	JCR		
5	Out Side Diameter	Dr. No.	730 H/H, Step 00, 743.4 H/H	Tabber 1°	
6	Inside Diameter	Dr. No.	630.12 H/H	Step length 293 H/H	
7	Width of Pellet Die	Dr. No.	290 H/H	Undercut = 0.7 H/H	
8	Grooves as per Drawing	Dr. No.	15x8x5 H/H   15x8x5 H/H		
9	Fitting Sizes on CNC Plate	Dr. No.	OK		
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		N/C Shop	[ Tapping size of holes 16 Hole Side ]	
12	Tapping PCD		685 H/H		
13	Tapping Hole Diameter		M20 - Check by M20 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth. 20.3 H/H	Tapping Depth. 18.6 H/H	
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ravi 21/12/24		
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		Len = 52	
2	External Relief Dia	3.5 H/H	Outside (3-3)	Inner	
3	External Relief Depth		23 H/H	17 H/H	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Romace		
6	Material Sent For Hardening On Date		21	12	24
Inspected By (Sign) & Date			Ravi 21/12/24		

Reviewed by (Engineer-CNC)

Manager-QA