



# 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.		13599 ✓	35/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 20/10/599
3	Pallet Die No.		12922 (B.0) n/c	Rev. n/c
4	Die Category	Drg. No.	H. Tambu	
5	Out Side Diameter	Drg. No.	680 n/c, Step OD = 682 n/c	Tap hole
6	Inside Diameter	Drg. No.	580.12 n/c	Step length = 345
7	Width of Pellet Die	Drg. No.	266 n/c	Under cut = 21 n/c
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 n/c   28.5 x 6 x 12 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of H. No. 12 Both side
12	Tapping PCD		680 n/c	
13	Tapping Hole Diameter		HIG = Check by HIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25.2 n/c	Tapping Depth = 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/1/25	
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		Counter = 60° Ravi 4/2
2	External Relief Dia	3.3 n/c	outside 3-39	Inner
3	External Relief Depth		21 n/c	15 n/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		4	25
Inspected By (Sign) & Date			Ravi 4/1/25	

Reviewed by (Engineer-CNC)

Manager-QA