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# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13747 ✓	42/45 ✓
2	Machined By		V. T. L. H/c Shop	Dr. H. L. D. 2016
3	Pallet Die No.		12973 (3.5) H/c	Rev. 00 ✓
4	Die Category	Drg. No.	M. Tombu	
5	Out Side Diameter	Drg. No.	69.04 H/c, Step 00.702.8 H/c	Tapper 4°
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 29.5
7	Width of Pellet Die	Drg. No.	250 H/c	Under cut - 6.4 H/c
8	Grooves as per Drawing	Drg. No.	24.5 x 9 H/c / 24 x 5 x 9 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes, 12 Back Side
12	Tapping PCD		655 H/c	
13	Tapping Hole Diameter		MIG - Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 24.2 H/c	Tapping Depth 22.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 6/1/25

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

Counter: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.3 H/c	Outside (2-3)		Inner				
3	External Relief Depth		10 H/c		3 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		6	1	25				

**Inspected By (Sign) & Date**

Ravi 6/1/25

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Reviewed by (Engineer-CNC)

Manager-QA