



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8989

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.		13928	33/50
2	Machined By		V.T.L. N/C Shop	Drg No. 13.02.844
3	Pallet Die No.		12017 (3.0) H4	Rev. 00
4	Die Category	Drg. No.	NJ&D	
5	Out Side Diameter	Drg. No.	700 H4, Step 0.0, 692 H4	Step length 9.5
6	Inside Diameter	Drg. No.	600.12 H4	
7	Width of Pellet Die	Drg. No.	265 H4	
8	Grooves as per Drawing	Drg. No.	15x8x7 H4 / 15x8x7 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping dia of holes 16 Both Side
12	Tapping PCD		640 H4	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H4	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 13/1/25

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	3.5 H4	Outside (3-3)		Inner					
3	External Relief Depth		23 H4		17 H4					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		13		25					

### Inspected By (Sign) & Date

Ravi 13/1/25

13/1/25

Reviewed by (Engineer-CNC)

Manager-QA