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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
Rev. Date	31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13865	40/50
2	Machined By		V.T.L. HLC Shop	Dy. No. 1-2009980
3	Pallet Die No.		13710 (4.0) HLC	Row: 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	6.00 HLC, Step 0.0, Tapper: 12°	
6	Inside Diameter	Drg. No.	5.20 HLC	Step length: 12.5
7	Width of Pellet Die	Drg. No.	22.2 HLC	
8	Grooves as per Drawing	Drg. No.	1348x5 HLC / 1348x5 HLC	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	Tapping HLC of holes: 12° Both Side
12	Tapping PCD		56.5 HLC	
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 HLC Tapping Depth 18.5	
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	4.5 HLC	Outside (3-3)		Inner				
3	External Relief Depth		14 HLC		10 HLC				
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	1	25				

### Inspected By (Sign) & Date

Ravi 13/1/25

Reviewed by (Engineer-CNC)   
 S. S. 13/1/25

Manager-QA