



# 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

9008

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13934	40/55
2	Machined By		V. T.L. H/c Shop	Qty No. 18.924 10
3	Pallet Die No.		13600 (80) H/c	Revised
4	Die Category	Drg. No.	58810	
5	Out Side Diameter	Drg. No.	630 H/c	Step OD, 634 H/c, Tapper = 12
6	Inside Diameter	Drg. No.	590.12 H/c	Step length 8 H/c
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c   13x8x3 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 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 90.2 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 16/1/25

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

Count 22.65  
Rep = 14

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5 H/c	Outside (2-3)	Inner			
3	External Relief Depth		93 H/c	15 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		16	1	25		

### Inspected By (Sign) & Date

Ravi 16/1/25

Setu 16/1/25

Reviewed by (Engineer-CNC)

Manager-QA