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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.		135726/14063 ✓	45/50 ✓
2	Machined By		V.T.C. H/C Shop	Dy. Insp. L. S. Ch. 13/7/13
3	Pallet Die No.		14244 (6.0) H/C	Rev. 100 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.4 H/C Step 002	491 H/C Step length 175
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of holes 2 Bolt Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		M2 x 2 Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 18.3 H/C	Tapping Depth 18.6 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/1/25

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							Rev 15
2	External Relief Dia	6.5 H/C	Outside (2-2)		Inner				
3	External Relief Depth		11 H/C		5 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		27	1	25				

### Inspected By (Sign) & Date

Ravi 27/1/25

Satish 27/1/25

Reviewed by (Engineer-CNC)

Manager-QA