

9/09



# 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.		14006	38/40
2	Machined By		V.T.L. H/c Shop	Dy. Mgr. Lark 3310
3	Pallet Die No.		13302 (4.0) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	4.99 H/c Step OD: 4.9 H/c	Step length 12.4
6	Inside Diameter	Drg. No.	4.20 ± 0.02 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	[ Tapping No. of holes = 8 Both Side ]
13	Tapping Hole Diameter		H202 Check by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.3 H/c Tapping Depth: 16.8 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi: 30/1/25

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**

1	Counter Sinking Depth & Finish	ok								Counter: 60 Ravi: 20
2	External Relief Dia	4.5 H/c	Outside 2.2		Inner					
3	External Relief Depth		6 H/c		2 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		20	1	25					

**Inspected By (Sign) & Date**

Ravi: 30/1/25

Satya 30/1/25

Reviewed by (Engineer-CNC)

Manager-QA