



# 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)

9189

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14133 ✓	34/50 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Drg. No. 1-20-450
4	Die Category	Drg. No.	13162 (2.8) H/C	Rev 200 ✓
5	Out Side Diameter	Drg. No.	J&W	
6	Inside Diameter	Drg. No.	730 H/C ✓	Step 00, 743.4 H/C, Tappet 15°
7	Width of Pellet Die	Drg. No.	630.12 H/C	Step length 33 H/C
8	Grooves as per Drawing	Drg. No.	290 H/C	Under cut 2.635 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x5 H/C   15x8x5 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	Tapping No. of holes = 16 Both Side
13	Tapping Hole Diameter		685 H/C ✓	
14	Tapping On Second Side	Half pitch of 1st side	M20 - C. back by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 H/C	Tapping Depth 18.6
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Sasi: 13/2/25

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° Row = 53
2	External Relief Dia	3.3 H/C	Outside (3-3)		Inner			
3	External Relief Depth		22 H/C		16 H/C			
4	Inspection Done Before Hardening By (Name)							Sasi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		13	2	23			

### Inspected By (Sign) & Date

Sasi: 13/2/25

Reviewed by (Engineer-CNC)

Manager-QA