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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.		14048	23/33/66
2	Machined By		V. T. L. n/c Shop	Dy. No. 1302/320
3	Pallet Die No.		14028 (B.O) n/c	Rev. of
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	6801 n/c	Step on 692.8 n/c Tapper 3"
6	Inside Diameter	Drg. No.	546.12 n/c (Rev. 548.1) n/c	Step length 31mm
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.2 n/c
8	Grooves as per Drawing	Drg. No.	3247+9.1 n/c   3247+9.1 n/c	(408) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step (2 mm Deep Both Side)
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping No. of Holes 2 Both Side
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 n/c	Tapping Depth 31.7 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 14/2/25

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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

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1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 n/c   7.0 n/c	6.5 n/c	All Rows = 43 n/c					
3	External Relief Depth		7.0 n/c	All Rows = 33 n/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Perforce					
6	Material Sent For Hardening On Date		14	2	25				

### Inspected By (Sign) & Date

Ravi 14/2/25

Satyam 14/2/25

Reviewed by (Engineer-CNC)

Manager-QA