



# 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)

9269

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14218	50/53
3	Pallet Die No.		V. T. L. N/C Shop	Drilling No. 12.02950
4	Die Category	Drg. No.	14147 (3.8) H/H	Rev. 00
5	Out Side Diameter	Drg. No.	M. Jamba	
6	Inside Diameter	Drg. No.	715.8 H/H Step 00: 692.8 H/H	Tapper: 12°
7	Width of Pellet Die	Drg. No.	600.12 H/H	
8	Grooves as per Drawing	Drg. No.	222 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 7 H/H / 12 x 8 x 7 H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		64 H/H	
14	Tapping On Second Side	Half pitch of 1st side	M20, Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Repture 20.3 H/H Tapping Depth 18 H/H	
17	Visual Inspection Before Gun Drilling		yes	

### Inspected By (Sign) & Date

Ravi 24/2/25

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 - 1 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	4.3 H/H	60 Side (3-3)	Inner				Rev. 53
3	External Relief Depth		16 H/H	8 H/H				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		24	2	25			

### Inspected By (Sign) & Date

Ravi 24/2/25

Reviewed by (Engineer-CNC)

Manager-QA