



# 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.		14260	36/44/50
2	Machined By		V. T. L. H/C Shop	Drilled 1.92 x 14.25
3	Pallet Die No.		13877 (3.0) H/C	Revised
4	Die Category	Drg. No.	MJEW	
5	Out Side Diameter	Drg. No.	70 H/C, Step 00, Tap 12	
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 17.7 H/C
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15 x 8 x 7 H/C   15 x 8 x 7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 18 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M20, Check by New Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 25/2/25	
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	
<b>Note : Mark the defective holes/missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter 60 Ravi 47
2	External Relief Dia	3.5 H/C / 4.0 H/C	3.5 H/C	All Holes = 14 H/C
3	External Relief Depth	4.0 H/C	4.0 H/C	All Holes = 6 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		25	25
Inspected By (Sign) & Date			Ravi 25/2/25	

Sets 25/2/25

Reviewed by (Engineer-CNC)

Manager-QA