



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6039

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.			
2	Machined By		10157	33/66
3	Pallet Die No.		V.T.L H/c Shop	Drg No. I.S.O-609
4	Die Category	Drg. No.	10887 (A.O) H	Rev 01
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.69 H Step 602 693 H	Tappers 8°
7	Width of Pellet Die	Drg. No.	548.12 H	Step length 31 H
8	Grooves as per Drawing	Drg. No.	195 H	Under dia 2.5 H
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x8.1 H   32x7x8.1 H (4x8) H	
10	Drilling Area Surface Smoothness		OK	Face Side Step 2 H Back Both side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H	
13	Tapping Hole Diameter		N162 Check by H/c Bolt	Tapping No. of holes: 4
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth. 33.4 H	Tapping Depth. 31.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date		Ravi 9/9/23	
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					Counters 30°
2	External Relief Dia	1.5 H	1.5 H	All Lines			Rev 12
3	External Relief Depth			33 H			
4	Inspection Done Before Hardening By (Name)	Ravi					
5	Material Sent For Hardening By (Name)	Lark Furnace					
6	Material Sent For Hardening On Date	9	9	23			
Inspected By (Sign) & Date		Ravi 9/9/23					

Reviewed by (Engineer-CNC)  
 9/9/23

Manager-QA