



# 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.		10087	42/73/90
2	Machined By		N.T.L. N/C Step	Drg. No. 1.3.0. 738
3	Pallet Die No.		11172 (8.0)mm	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	780mm Step 06, 703mm	Tappers 4"
6	Inside Diameter	Drg. No.	800.12 mm	Step length 93mm
7	Width of Pellet Die	Drg. No.	921mm	
8	Grooves as per Drawing	Drg. No.	57x6x10mm   57x8x10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Step	Tapping dia of holes 12 Both Side
12	Tapping PCD		655mm	
13	Tapping Hole Diameter		MIC 2 Check by MIC Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 94.5mm	Tapping Depth 93.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 26/10/23

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							Ravi
2	External Relief Dia	8.5mm/9.0mm	8.5mm All Lines	9.0mm All Lines					
3	External Relief Depth		48mm	17mm					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		26	10	23				

### Inspected By (Sign) & Date

Ravi 26/10/23

Reviewed by (Engineer-CNC)

Manager-QA