



# 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

6745

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11023 ✓	55/55
2	Machined By		V.T.G. H/c Shop	Drg. No. 13.0 = 6 GG
3	Pallet Die No.		11630 (3.0) H/c	Rec. No. ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	709 H/c Step OD = 692.3 H/c	Tapper = 12
6	Inside Diameter	Drg. No.	600.12 H/c	Step length = 19.2 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/c / 12x10x7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of H/c = 12 Back Side
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		H/c = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.2 H/c Tapping Depth = 18.3 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 9/1/24

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

Count = 60

1	Counter Sinking Depth & Finish	ok						Count = 18
2	External Relief Dia	8.5 H/c	8.5 Side	Inner				
3	External Relief Depth		5 H/c	Nil				
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	1	24			

### Inspected By (Sign) & Date

Ravi 9/1/24

Reviewed by (Engineer-CNC)

Manager-QA