



# 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.		10989	55/86	
2	Machined By		V. T. L n/c Shop	Drilling No. 68.029 36	
3	Pallet Die No.		11771 (3.5) n/c	Rev. 01	
4	Die Category	Drg. No.	S. Jumbo		
5	Out Side Diameter	Drg. No.	1039.1 n/c Step 002 1039.9 n/c	Tapping 3	
6	Inside Diameter	Drg. No.	900.12 n/c 900.14 n/c	Step lengths 32 n/c 32.2 n/c	
7	Width of Pellet Die	Drg. No.	375 n/c	Undercut 0.4 n/c	
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 n/c 29.5 x 8 x 13 n/c		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		n/c Shop	Tapping No. of Holes - 15 Back Side	
12	Tapping PCD		970 n/c		
13	Tapping Hole Diameter		M24 Check by M24 Ball		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth 38.8 n/c	Tapping Depth 38 n/c	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 19/8/24	2 slot	
1	As per programme no.			32.1 n/c width	
2	Gun Drilling Work Completed On			7.5 n/c Depth	
3	Hole Finish In Gun Drilling	Marked	ok	Back Side	
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		Counter = 60 Low = 59	
2	External Relief Dia	4.0 n/c	Outside 4-4	Inner	
3	External Relief Depth		18 n/c	11 n/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		19	2	24
Inspected By (Sign) & Date			Ravi 19/8/24		

Reviewed by (Engineer-CNC)

Manager-QA