



# 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.		11303	39/51
2	Machined By		V. T. L. n/c stop	Dy No 13.02 537
3	Pallet Die No.		10774 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	730.1 n/c Step 00, 743.1 n/c Tapper	4"
6	Inside Diameter	Drg. No.	630.1 2 n/c	Step length 27.5
7	Width of Pellet Die	Drg. No.	255 n/c	Under cut = 5.4 n/c
8	Grooves as per Drawing	Drg. No.	22 x 27 7 n/c / 22 x 27 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c stop	Tapping No of holes = 12 Both Side
12	Tapping PCD		685 n/c	
13	Tapping Hole Diameter		M22, Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 29 n/c Tapping Depth 27 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 20/8/24*

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 *Counters 60°*

1	Counter Sinking Depth & Finish	ok									<i>Rev 2.00</i>
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner						
3	External Relief Depth		18 n/c		12 n/c						
4	Inspection Done Before Hardening By (Name)									<i>Ravi</i>	
5	Material Sent For Hardening By (Name)									<i>Lark Furnace</i>	
6	Material Sent For Hardening On Date										

Inspected By (Sign) & Date *Ravi 20/8/24*

Reviewed by (Engineer-CNC)

Manager-QA