



# Lark Engineering Company (India) Pvt. Ltd.

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

Form No. CNC/OA/FM/02

Rev. No. 01

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11419	45/45
2	Machined By		V.T.L n/c Shop	Dy No. 130, 296
3	Pallet Die No.		11738 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	690 n/c	Step length = 23.5
6	Inside Diameter	Drg. No.	600.12 n/c	Tapper 4°
7	Width of Pellet Die	Drg. No.	250 n/c	Under cot = 6.5 n/c
8	Grooves as per Drawing	Drg. No.	24x5x9 n/c / 24x5x9 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 = 10 Bottom Side ]
12	Tapping PCD		655 n/c	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25 n/c Tapping Depth 23 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 21/3/24

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 - 1 Hole Colused (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		4 n/c		Null				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Romane
6	Material Sent For Hardening On Date			7	3	24			

Inspected By (Sign) & Date Ravi 21/3/24

Sat 21/3/24  
Reviewed by (Engineer-CNC)

Manager-QA