



# 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)

7074

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11427	32/40
2	Machined By		V. T. L H/C Shop	Digital Lark 8310
3	Pallet Die No.		11279(3-5)H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H H Step OD = 49 H H	Step length = 17.4
6	Inside Diameter	Drg. No.	480.12 H H	
7	Width of Pellet Die	Drg. No.	158.1 H H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H H / 12x8x3 H H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of holes = 8 Both Side
12	Tapping PCD		454 H H	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19 H H Tapping	Depth = 17 H H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/3/24	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter = 60°
2	External Relief Dia	3.8 H H	Outside (2-2)	Inner
3	External Relief Depth		12 H H	8 H H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		8	3
Inspected By (Sign) & Date			Ravi 8/3/24	

Reviewed by (Engineer-CNC)

Manager-QA