



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11390	36/50
2	Machined By		V.T.C. HLC Shop	Dry Hdg 13.0.119
3	Pallet Die No.		11018 (3.0) HLC	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 HLC / Step 00 = 693 HLC	Step length 19.4
6	Inside Diameter	Drg. No.	600.12 HLC	
7	Width of Pellet Die	Drg. No.	222 HLC	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 HLC / 12.5 x 8 x 7 HLC	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		HLC Shop	Tapping No. of holes. 12 Back Side
12	Tapping PCD		645 HLC	
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 22.6 HLC	Tapping Depth 20.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 12/3/24

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

Counter = 65

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 HLC	Outside (3-3)		Inner				
3	External Relief Depth		20 HLC		14 HLC				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		12	3	24				

### Inspected By (Sign) & Date

Ravi 12/3/24

Reviewed by (Engineer-CNC)

Manager-QA