



# Lark Engineering Company (India) Pvt. Ltd.

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

7/11/15 2012

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.		11399	36/66
2	Machined By		V. Tal. n/c Shop	Drill No. 1.5.0.6-9
3	Pallet Die No.		11912 (10.0) n/c	Revol
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c / Step on 693 n/c	Tapbers 8°
6	Inside Diameter	Drg. No.	548.14 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.5
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c   32 x 7 x 8 n/c	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 9 n/c
10	Drilling Area Surface Smoothness		ok	Deep Both side
11	Tapping Operator		n/c Shop	Tapping no
12	Tapping PCD		619 n/c	of holes = 4
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Rept. 33.8 n/c	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/3/24

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							Counters 6°
2	External Relief Dia	11.0 n/c	All Reqs						
3	External Relief Depth		Both						
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forware
6	Material Sent For Hardening On Date		16	3	24				

Inspected By (Sign) & Date

Ravi 16/3/24

Satyam 16/3/24

Reviewed by (Engineer-CNC)

Manager-QA