



# 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.		11456	33/53/79
2	Machined By		V.T.G. H/C Shop	Dr. Has 13.9.17
3	Pallet Die No.		11788 (6.0) H/C	Rev. 01
4	Die Category	Drg. No.	S. Jamba	
5	Out Side Diameter	Drg. No.	1008 H/C	Step 002 1003 H/C
6	Inside Diameter	Drg. No.	850.12 H/C	Tap length 41 H/C
7	Width of Pellet Die	Drg. No.	266 H/C	Under cut 2.4 H/C
8	Grooves as per Drawing	Drg. No.	45x8x10 H/C	45x8x10 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face groove
10	Drilling Area Surface Smoothness		ok	2mm deep
11	Tapping Operator		H/C Shop	Tapping No. of holes 2 Both Side
12	Tapping PCD		935 H/C	
13	Tapping Hole Diameter		H20: Check by H20 B3 L	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 40.8 H/C	Tapping Depth 40.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Raoi 29/3/24

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 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H/C	7.0 H/C	6.5 H/C	All Rows	7.0 H/C	All Rows		
3	External Relief Depth				46 H/C		26 H/C		
4	Inspection Done Before Hardening By (Name)				Raoi				
5	Material Sent For Hardening By (Name)				Lark Roshore				
6	Material Sent For Hardening On Date				29	3	24		

### Inspected By (Sign) & Date

Raoi 29/3/24

Satya 29/3/24

Reviewed by (Engineer-CNC)

Manager-QA