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# 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.		11681	50/66
2	Machined By		V.T.L. H/c Shop	Drg No. L. 2. 0. 609
3	Pallet Die No.		12247 (8.0) H/c	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c Step OD 698.8 H/c	Tapper. 2
6	Inside Diameter	Drg. No.	548.14 H/c	Step length 3 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.45
8	Grooves as per Drawing	Drg. No.	32x7x8 H/c   32x7x8 H/c (4x8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Face side step 9 H/c Deep Both side ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	[ Tapping H/c of holes 4 Both side ]
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		N/c Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 H/c Tapping Depth 31.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

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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 300

1	Counter Sinking Depth & Finish	ok								Rev. 10
2	External Relief Dia	9.0 H/c	All Rows							
3	External Relief Depth		16 H/c							
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Forance
6	Material Sent For Hardening On Date									11 4 24

**Inspected By (Sign) & Date**

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Reviewed by (Engineer-CNC)

Manager-QA