



# 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.		11670/	33/53/66
2	Machined By		V. T. L. H/O Shop	Drg. No. 125.0 2609
3	Pallet Die No.		12039 (G.O) H/O	Revised
4	Die Category	Drg. No.	M. Jumba	
5	Out Side Diameter	Drg. No.	620.7 H/O, Step on, 698.8 H/O	Tabbers 8
6	Inside Diameter	Drg. No.	548.12 H/O	Step length 2.14 H/O
7	Width of Pellet Die	Drg. No.	195 H/O	Undercut 2.45 H/O
8	Grooves as per Drawing	Drg. No.	32x7x8 H/O   32x7x8 H/O (4x8) H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Steps
10	Drilling Area Surface Smoothness		ok	Back Back Side
11	Tapping Operator		H/O Shop	Tapping No of holes 4 Back Side
12	Tapping PCD		619 H/O	
13	Tapping Hole Diameter		NIG 2 Check by HIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.0 H/O	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/4/24

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							Compter 30
2	External Relief Dia	6.5 H/O   7.0 H/O	6.5 H/O All Rows	7.0 H/O All Rows					
3	External Relief Depth		33 H/O		13 H/O				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Pernore
6	Material Sent For Hardening On Date		13	4	24				

Inspected By (Sign) & Date

Ravi 13/4/24

Reviewed by (Engineer-CNC)

Manager-QA