



# 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.		11938	34/55
2	Machined By		V.T.L. H/C Shop	Dy. No. 13.02.407
3	Pallet Die No.		12196 (4-2) H/C	Rev. No.
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/C ✓ Step 0.2-0.92 ✓ 8 H/C ✓	Tabber 12
6	Inside Diameter	Drg. No.	600.12 H/C ✓	Step length 8 H/C ✓
7	Width of Pellet Die	Drg. No.	222 H/C ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C ✓ 12x8x7 H/C ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tabbing H/C of 12.02.12 Bohr Side
12	Tapping PCD		640 H/C ✓	
13	Tapping Hole Diameter		H20: Check by H20 B01 ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/C ✓	Tabbing Depth 18.8 H/C ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 14/5/24

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							Counter: G-2 Row: 32
2	External Relief Dia	4.5 H/C ✓	Outside (2-3)		Inner				
3	External Relief Depth		25 H/C ✓		21 H/C ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		14	5	24				

### Inspected By (Sign) & Date

Ravi 14/5/24

Reviewed by (Engineer-CNC)

Manager-QA