



# 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.		12228	39/52
2	Machined By		V. TIL. n/c Shop	Qty No. 1.30547
3	Pallet Die No.		12214(3.0) n/c	Rev 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	704 n/c Step 00.693 n/c	Tapper 2.2"
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 2.30 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12210 or 7.5 n/c   12210 or 7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Botu Side
12	Tapping PCD		340 n/c	
13	Tapping Hole Diameter		M20 Check by Neo Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 18/6/24

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 2.60"
2	External Relief Dia	3.5 n/c	outside (3.3)		inner			Rev 28
3	External Relief Depth		19 n/c		13 n/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		18	6	24			

### Inspected By (Sign) & Date

Ravi 18/6/24

Reviewed by (Engineer-CNC)

Manager-QA