



# 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.		12386	35/50/66
2	Machined By		V.T.L. n/c Shop	Dry No. 1.9.0.809
3	Pallet Die No.		12788 (6.0) n/c	Revol
4	Die Category	Drg. No.	M-Tumbo	
5	Out Side Diameter	Drg. No.	68.07 n/c, 3rd 002 693 n/c	Tappers 3°
6	Inside Diameter	Drg. No.	548.12 n/c	Side length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32x7x8 n/c   32x7x8 n/c	(4x8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Face side Step 2nd Back Both Side]
12	Tapping PCD		619 n/c	Tapping of holes
13	Tapping Hole Diameter		M16: Check by M16 Bolt	of holes
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 32 n/c	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 19/7/24

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					Counters 30°
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Rows	7.0 mm All Rows			Rep: 12
3	External Relief Depth		31 mm	16 mm			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		19	7	24		

**Inspected By (Sign) & Date**

Ravi 19/7/24

Reviewed by (Engineer-CNC)

Manager-QA