



# 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.		124P3	40/48/55
2	Machined By.		V.T.L M/C SHOP	Dry H. 1.8.021-90
3	Pallet Die No.		12494 (3.5) H.H.	Raw 20
4	Die Category	Drg. No.	<del>12494</del> Jumbo	
5	Out Side Diameter	Drg. No.	770 H.H. Step 00, 792 H.H. Side length 30.5	
6	Inside Diameter	Drg. No.	660.12 H.H.	Under cut 11 H.H.
7	Width of Pellet Die	Drg. No.	324 H.H.	
8	Grooves as per Drawing	Drg. No.		
9	Fitting Sizes on CNC Plate	Drg. No.	Ø1.5 x 8 x 8 H.H. / Ø1.5 x 8 x 8 H.H.	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		785 H.H.	Tapping No. of holes 12 Both side
13	Tapping Hole Diameter		M2 x Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 31 H.H.	Tapping Depth 29.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Rao: 23/7/24

1	As per programme no.		→
2	Gun Drilling Work Completed On		→
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		N-

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK				Center 0.0
2	External Relief Dia	4.2 H.H. / 4.5 H.H.	4.2 H.H. All Rows	4.5 H.H. All Rows		Raw 251
3	External Relief Depth		15 H.H.	7 H.H.		
4	Inspection Done Before Hardening By (Name)		Rao			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		23	7	24	

### Inspected By (Sign) & Date

Rao: 23/7/24

Reviewed by (Engineer-CNC)

Manager-QA