



# 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.		12432	35/50/70
2	Machined By		V.T.L. H/c Shop	Dr. No. 1.3.2. 648
3	Pallet Die No.		12958 (6.0) H/c	Rev. 09
4	Die Category	Drg. No.	HJ&D	
5	Out Side Diameter	Drg. No.	712 H/c, Step OD: 777mm/778mm	
6	Inside Diameter	Drg. No.	572.12 H/c	675 H/c Step length = 42mm/24
7	Width of Pellet Die	Drg. No.	270 H/c	Under cut = 32.5 H/c
8	Grooves as per Drawing	Drg. No.	106x8x12 H/c / 88x8x12 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of 4 Nos. 6
12	Tapping PCD		660 H/c	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 2nd Side 1810	Tapping Depth: 33
15	Tapping Hole Depth		Drill Depth: 35.4 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 7/8/24

1	As per programme no.			1 Slot 39 mm width 28 mm Depth
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							Countersink 60
2	External Relief Dia	6.5 H/c / 7.0 H/c	6.5 H/c All Rows	7.0 H/c All Rows					
3	External Relief Depth		35 H/c	20 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		7	8	24				

### Inspected By (Sign) & Date

Ravi 7/8/24

Reviewed by (Engineer-CNC)

Manager-QA