



# 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.		10028	27/47/70
2	Machined By		V.T. L N/C Shop	Drg No. 1.S.D. 377
3	Pallet Die No.		10578 (6.5) N/C	Rev 203
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	688 N/C Step OD: 697.7 N/C	Step length: 38.5
6	Inside Diameter	Drg. No.	548.12 N/C	Tapper: 5°
7	Width of Pellet Die	Drg. No.	214.9 N/C	Undercut: 1.8 N/C
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 N/C / 29.4 x 10 x 8 N/C	(6 x 8) N/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step Deep Bottom side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of Holes: 2 Bottom Side
12	Tapping PCD		618 N/C	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 32.3 N/C	Tapping Depth: 30.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/8/23

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: 23°
2	External Relief Dia	7.0 N/C / 7.5 N/C	7.0 N/C All Lines	7.5 N/C All Lines		Rows: 14
3	External Relief Depth		4.3 N/C	2.3 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		7	8	23	

### Inspected By (Sign) & Date

Ravi 27/8/23

Reviewed by (Engineer-CNC)

Manager-QA