



# 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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12867	42/50
2	Machined By		V.T.L M/c Shop	Drg No- LSD 71
3	Pallet Die No.		13093 (4.0mm)	(REV00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm Step od- 623.9mm	Step Length- 17mm
6	Inside Diameter	Drg. No.	520.12mm	Tapper- 12°
7	Width of Pellet Die	Drg. No.	222mm	Under wt- 1.9mm
8	Grooves as per Drawing	Drg. No.	9x10x4mm 9x10x4mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
1	Tapping Operator		M/c Shop	Tapping Holes of Holes 12 Both Side
2	Tapping PCD		565mm	
3	Tapping Hole Diameter		M202 Check by M20 Ball	
4	Tapping On Second Side	Half pitch of 1st side	ok	
5	Tapping Hole Depth		Drill Depth 20.4mm	
6	Perpendicularity of Tapped Hole		yes	
7	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Soni 14/9/24	
As per programme no.				
Gun Drilling Work Completed On				
Hole Finish In Gun Drilling	Marked		ok	
Defective Holes (If Any)			No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
Counter Sinking Depth & Finish	ok			Considered Good Now: 32
External Relief Dia	4.5mm	Outside (3-3)	Inner	
External Relief Depth		12mm	8mm	
Inspection Done Before Hardening By (Name)			Soni	
Material Sent For Hardening By (Name)			Lark Furnace	
Material Sent For Hardening On Date		14	9	24
Inspected By (Sign) & Date			Soni 14/9/24	

Soni 14/9/24  
Inspected by (Engineer-CNC)

Manager-QA