



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8133

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.		12863	35/55
2	Machined By		V.T.I. H/c Shop	Drilling No. L-302457
3	Pallet Die No.		12780 (3.3) H/c	Rev = 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 H/c	
6	Inside Diameter	Drg. No.	Step 002 800 H/c	Step length 28 H/c
7	Width of Pellet Die	Drg. No.	660.2 H/c	26.3
8	Grooves as per Drawing	Drg. No.	316 H/c	Under cut = 15 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	20x8x7.5 H/c / 20x8x7.5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		725 H/c	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 25.4 H/c	Tapping Depth = 23.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 19/9/24

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 = 1 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	OK					Counter = 60°
2	External Relief Dia	4.3 H/c	outside (3-3)		Inner		Pop = 47
3	External Relief Depth		24 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		19	9	24		

### Inspected By (Sign) & Date

Ravi 19/9/24

Saty 19/9/24

Reviewed by (Engineer-CNC)

Manager-QA