



# 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.			
2	Machined By		12527	43/50
3	Pallet Die No.		V.T.L. H/c Shop	Dry H/c L.S.D. 885
4	Die Category	Drg. No.	11869(4.0)H/H	Rev. 00
5	Out Side Diameter	Drg. No.	58510	
6	Inside Diameter	Drg. No.	620H/H, Step 00, 624H/H	Tabber 12°
7	Width of Pellet Die	Drg. No.	520.12H/H	Step length 20.1H/H
8	Grooves as per Drawing	Drg. No.	186H/H	Under cut = 2mm
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H/H / 13x8x3H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping H/c of Holes, 12° Both Side
13	Tapping Hole Diameter		565H/H	
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 20.5H/H	Tapping Depth: 18.5
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 11/10/24

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

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

1	Counter Sinking Depth & Finish	ok					Counter: 60° Ravi 25
2	External Relief Dia	4.5H/H	outside (3-3)		Inner		
3	External Relief Depth		11H/H		7H/H		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		1	10	24		

### Inspected By (Sign) & Date

Ravi 11/10/24

Reviewed by (Engineer-CNC)

Manager-QA