



# 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.		12956	28/38/66
2	Machined By		V.T.L n/c Shop	Dry H <sub>2</sub> 1.8.0.609
3	Pallet Die No.		13333 (6.0) n/c	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c	Step OD. 693 n/c Tapper. 8°
6	Inside Diameter	Drg. No.	547.12 n/c / 547.9 n/c	Step length. 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Undercut = 9.45 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c / 32 x 7 x 8 n/c (4 x 8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	9 n/c Deep Both Side
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		619 n/c	of 4.18.2
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 34.8 n/c	Tapping Depth = 32
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 14/10/24

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

Counter = 30°  
Row = 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c	All Rows	7.0 n/c	All Rows	
3	External Relief Depth		38 n/c		38 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		14	10	24		

### Inspected By (Sign) & Date

Ravi 14/10/24

Reviewed by (Engineer-CNC)

Manager-QA