

# 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.		13085	39/51
2	Machined By		V.T.L H/c Shop	Dy No. 1-802537
3	Pallet Die No.		11542 (3.0) H/H	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	732 H/H	Step 00 = 743 H/H
6	Inside Diameter	Drg. No.	630.12 H/H	Tabber = 4°
7	Width of Pellet Die	Drg. No.	255 H/H	Step length = 7.5
8	Grooves as per Drawing	Drg. No.	22x8x7 H/H	Under cut = 5.5 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	22x8x7 H/H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		685 H/H	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		M22 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 28.4 H/H	Tapping Depth = 28.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 21/10/24

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 = 42
2	External Relief Dia	3.5 H/H	Outside (3.5)		Inner			
3	External Relief Depth		18 H/H		12 H/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		21	10	24			

### Inspected By (Sign) & Date

Ravi 21/10/24

Satyam 21/10/24

Reviewed by (Engineer-CNC)

Manager-QA