



# 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.			
2	Machined By		13128	36/50
3	Pallet Die No.		V.T.L. H/c Shop	Dy No. 1-2-3-12501
4	Die Category	Drg. No.	12558(3.0) H/c	Rev: 01
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	700 H/c, 31 ep 00 = 693 H/c	Tabber = 12"
7	Width of Pellet Die	Drg. No.	600.12 H/c	Step length = 5mm
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7 H/c / 12x8x7 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	[ Tapping No of Holes = 12 Both Side ]
13	Tapping Hole Diameter		640 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Ball	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.4 H/c	Tapping Depth = 18.5
17	Visual Inspection Before Gun Drilling		yes	
			OK	

### Inspected By (Sign) & Date

Resi 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

Counter = 600

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 H/c	outside (3-3)		Inner				
3	External Relief Depth		20 H/c		14 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		21	10	24				

### Inspected By (Sign) & Date

Resi 21/10/24

Saty 21/10/24

Reviewed by (Engineer-CNC)

Manager-QA