



# 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.		12973	70/70
2	Machined By		V.T.L. n/c Shop	Drg No. 1202/162
3	Pallet Die No.		13428(10.0)H	Rev 2.00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1051 H	Step 002 1041 H Tappers 4°
6	Inside Diameter	Drg. No.	911.14 H / 911.12	Step length 29 H
7	Width of Pellet Die	Drg. No.	338 H	
8	Grooves as per Drawing	Drg. No.	33x10x11 H / 33x10x11 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Core Side Step 1111 Deep from Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of holes, 16
12	Tapping PCD		975 H	Both Side
13	Tapping Hole Diameter		M24. Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 41.3 H Tapping Depth = 29 H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 25/10/24

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 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	11.0 H	Outside (2-2)		Inner				
3	External Relief Depth		8 H		Nil				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		25	10	24				

### Inspected By (Sign) & Date

Ravi 25/10/24

Signature 25/10/24

Reviewed by (Engineer-CNC)

Manager-QA