



# 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)

8448

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13130	30/32/60
2	Machined By		V.T.L. H/c. Shop	Dry die 13.0.2017
3	Pallet Die No.		13806(4.0) H/c	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c Side OD, 792 H/c	Step length 38.5
6	Inside Diameter	Drg. No.	660.12 H/c	Under cut, 8 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c. Shop	
12	Tapping PCD		785 H/c	Tapping H/c of holes 12 Both Side
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 31.3 H/c	Tapping Depth 29.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 29/10/24

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°

1	Counter Sinking Depth & Finish	OK						Rev: 47
2	External Relief Dia	4.8 H/c   5.0 H/c	4.8 H/c All Rows = 30 H/c					
3	External Relief Depth		5.0 H/c All Rows = 28 H/c					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark For no ce					
6	Material Sent For Hardening On Date		29	10	24			

### Inspected By (Sign) & Date

Ravi 29/10/24

Reviewed by (Engineer-CNC)

Manager-QA