



# 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.		13135 ✓	40/50 ✓
2	Machined By		V.T.L. M/C Shop	Dry No. 13.1.1172
3	Pallet Die No.		12563 (4.0) ✓	Rev: 00 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	70mm / Step 002 693 ✓	Tapper 12°
6	Inside Diameter	Drg. No.	60.12 mm	Step length 20mm ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x5 mm / 12x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		840 mm ✓	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Tapping No. of holes 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/11/24

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°
2	External Relief Dia	4.5 mm	Outside (2-3)		Inner			Rev: 38
3	External Relief Depth		14 mm		10 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		4	11	24			

### Inspected By (Sign) & Date

Ravi 4/11/24

4/11/24

Reviewed by (Engineer-CNC)

Manager-QA