



# 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)

8705

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13399	40/50
2	Machined By		V.T.L n/c Shop	Dry Hole 1.80 9980
3	Pallet Die No.		13410 (4.0) n/c	Renew
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	6.20 n/c	
6	Inside Diameter	Drg. No.	Step 60. Taper 12°	
7	Width of Pellet Die	Drg. No.	5.20.12 n/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	2.2.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		56.5 n/c	Tapping No. of holes 12 Back Side
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 2.4 n/c	Tapping Depth 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 6/12/24

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 6°
2	External Relief Dia	4.5 n/c	outside (3-3)		Inner		Low 31
3	External Relief Depth		14 n/c		10 n/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		6	12	24		

### Inspected By (Sign) & Date

Ravi 6/12/24

Reviewed by (Engineer-CNC)

Manager-QA