



# 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.		13509	039/50
2	Machined By		V. T.L. H/c Shop	Dy No. 120998
3	Pallet Die No.		12602 (3.0) H/c	Per 2000
4	Die Category	Drg. No.	Extrusion side	
5	Out Side Diameter	Drg. No.	620 H/c / Step 002 Tapper 12" Step length 18.5	
6	Inside Diameter	Drg. No.	520.14 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of Hole 12 Back Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.6
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

Counter 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 H/c	Outside (2-3)		Inner				
3	External Relief Depth		17 H/c		11 H/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

Satish 6/12/24

Reviewed by (Engineer-CNC)

Manager-QA