



# 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 ✓	40/55 ✓
2	Machined By		N.T.L. H/C Shop	Drg No. 1802 4951
3	Pallet Die No.		12645 (8.0) H/C	Rev 200 ✓
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	630 H/C	Step 002 621.5 H/C
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 4.0 1.5
7	Width of Pellet Die	Drg. No.	222 H/C	Tabber ✓
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 No. of holes 12 Both 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. 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 12/12/24

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 = 600

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5 H/C	Outside (2.3)		Inner				
3	External Relief Depth		23 H/C		15 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Burnace
6	Material Sent For Hardening On Date		12	12	24				

### Inspected By (Sign) & Date

Ravi 12/12/24

Satya 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA