



# 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.		13370	42/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.02639
3	Pallet Die No.		14065(8.0)mm	Rev 200
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630mm Step OD = 624mm	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12mm	Step length = 13mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm   13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm	Tapping No. of Holes = 12 Both 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 = 20.3mm	Tapping Depth = 18.6mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi: 16/12/24

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°  
Ravi = 18

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5mm	Outside (3-3)		Inner		
3	External Relief Depth		21mm		13mm		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lapan Metal		
6	Material Sent For Hardening On Date		16	12	24		

### Inspected By (Sign) & Date

Ravi: 16/12/24

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Reviewed by (Engineer-CNC)

Manager-QA