



# 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.		13604	47/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1.50.1189
3	Pallet Die No.		13363(4.5)mm	Rev. 1.00
4	Die Category	Drg. No.	3210	
5	Out Side Diameter	Drg. No.	530mm, Step OD = 498.88	Tap Angle = 12°
6	Inside Diameter	Drg. No.	420.12 mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm / 12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 mm Tapping Depth 16.0 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 18/12/24

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

Coordinate 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	5.0 mm	Outside (2-2)		Inner					
3	External Relief Depth		12 mm		8 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		18	12	24					

### Inspected By (Sign) & Date

Ravi 18/12/24

Reviewed by (Engineer-CNC)

Manager-QA