



# 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.		13641	36/44/50
2	Machined By		V.T.L H/c Shop	Dy. No. L.E.C. 14805
3	Pallet Die No.		12014 (3.0) H4	Rev. 02
4	Die Category	Drg. No.	HJ&D	
5	Out Side Diameter	Drg. No.	701 H4 Step OD, Tappers 12°	
6	Inside Diameter	Drg. No.	600.12 H4	Step length. 17.1 H4
7	Width of Pellet Die	Drg. No.	265 H4	
8	Grooves as per Drawing	Drg. No.	15x8x7 H4 / 15x8x7 H4	
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 16 Both Side
12	Tapping PCD		640 H4	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 H4 Tapping Depth = 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Rasi 23/12/24

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° Row 47

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5 H4 / 4.0 H4	3.5 H4 All Rows	2	14 H4		
3	External Relief Depth		4.0 H4 All Rows	2	6 H4		
4	Inspection Done Before Hardening By (Name)		Rasi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		23	12	24		

### Inspected By (Sign) & Date

Rasi 23/12/24

23/12/24

Reviewed by (Engineer-CNC)

Manager-QA