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# 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.		13086	45/50
2	Machined By		V.T.L. H/C Shop	Drg No. L.S.D.1/30
3	Pallet Die No.		13055 (5.0) H/C	Rev. 2.0
4	Die Category	Drg. No.	38810	
5	Out Side Diameter	Drg. No.	620 H/C	Step 002 623.1 H/C
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 20 H/C
7	Width of Pellet Die	Drg. No.	186 H/C	Tapper 12°
8	Grooves as per Drawing	Drg. No.	13x8x3 H/C   13x8x3 H/C	Under cut 1.5 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	Tapping H. of holes 12 Back Side
13	Tapping Hole Diameter		H162 Check by H16 Belt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/C	Tapping Depth 18.6 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Raoi 25/12/24

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

1	Counter Sinking Depth & Finish	ok						Counter = 60°
2	External Relief Dia	5.5 H/C	Outside (3-2)		Inner			Relief = 21
3	External Relief Depth		10 H/C		5 H/C			
4	Inspection Done Before Hardening By (Name)							Raoi
5	Material Sent For Hardening By (Name)							Lark furnace
6	Material Sent For Hardening On Date		25	12	24			

### Inspected By (Sign) & Date

Raoi 25/12/24

*Signature*  
25/12/24

Reviewed by (Engineer-CNC)

Manager-QA