



# 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.			
2	Machined By		13701	36/50
3	Pallet Die No.		V.7.L H/c Shop	Dy. No. 1 & Co. 9980
4	Die Category	Drg. No.	13683(2.0)H/H	Revised
5	Out Side Diameter	Drg. No.	Ext. outside	
6	Inside Diameter	Drg. No.	6.20H/H, Step OD, Tapper 12°	Step length 18.5
7	Width of Pellet Die	Drg. No.	5.20 12 H/H	
8	Grooves as per Drawing	Drg. No.	2.22 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/H   13x8x5 H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	[ Tapping H <sub>0</sub> of Holes = 12 Both Side ]
13	Tapping Hole Diameter		5.65 H/H	
14	Tapping On Second Side	Half pitch of 1st side	H20 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.2 H/H Tapping Dept. 18.6 H/H	
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 26/12/24

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	3.5 H/H	Outside (3-3)		Inner				Len = 38
3	External Relief Depth		20 H/H		14 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Pomece				
6	Material Sent For Hardening On Date			26	12	24			

### Inspected By (Sign) & Date

Ravi 26/12/24

Jatun 26/12/24

Reviewed by (Engineer-CNC)

Manager-QA