



# 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.		13661	30/50
2	Machined By		N.T.L. H/C Shop	Drg. No. 13681
3	Pallet Die No.		13681 (3.0) H/C	Rev. No.
4	Die Category	Drg. No.	Centroid	
5	Out Side Diameter	Drg. No.	619.8 H/C	Step 00, Tapper, 12°
6	Inside Diameter	Drg. No.	520.12 H/C / 520.14 H/C	Step length 18.5
7	Width of Pellet Die	Drg. No.	22.2 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of Holes 12° Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 30/12/24

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/C	Outside (3.3)		Inner			
3	External Relief Depth		23 H/C		20 H/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		30	12	24			

### Inspected By (Sign) & Date

Ravi 30/12/24

Reviewed by (Engineer-CNC)

Manager-QA