



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13843 ✓	94/40 ✓
2	Machined By		V.T.L. H/C Shop	Drilling No. 13.0 = 1330
3	Pallet Die No.		13549 (3.0) H/C ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	H. Tumbo	
5	Out Side Diameter	Drg. No.	680 H/C, Step OD, 692.8 H/C	Tappers 12°
6	Inside Diameter	Drg. No.	600.12 H/C	Step lengths 80 H/C
7	Width of Pellet Die	Drg. No.	22.2 H/C	Wden cut = 6.4 H/C
8	Grooves as per Drawing	Drg. No.	14x8x7 H/C / 14x8x7 H/C	
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: 12 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M20: Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 22.3 H/C	Tapping Depth: 30.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 16/1/25

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				Rev: 38
3	External Relief Depth		19 H/C		16 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forhace
6	Material Sent For Hardening On Date		16	1	25				

### Inspected By (Sign) & Date

Ravi 16/1/25

Reviewed by (Engineer-CNC)

Manager-QA