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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.		13865 ✓	40/50 ✓
2	Machined By		V.T.L. H/c Shop	Dy No. 1.2.0.998
3	Pallet Die No.		13709 (4.0) H/H ✓	Rev. 00 ✓
4	Die Category	Drg. No.	9.2.2amide	
5	Out Side Diameter	Drg. No.	619.8 H/H Ø Step 00. Tapper 12°	
6	Inside Diameter	Drg. No.	520.12 H/H ✓	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/H ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H ✓	
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		565 H/H ✓	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/H Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 13/1/25

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

Counter 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/H	Outside (3-3)		Inner				
3	External Relief Depth		14 H/H		10 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark furnace				
6	Material Sent For Hardening On Date		13	1	25				

### Inspected By (Sign) & Date

Ravi 13/1/25

Reviewed by (Engineer-CNC)  
13/1/25

Manager-QA