



# 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.		13969	36/50
2	Machined By		N.T.L n/c Shop	Dy No. 13.0.019
3	Pallet Die No.		13552 (4.0) HH	
4	Die Category	Drg. No.	H. 70460	
5	Out Side Diameter	Drg. No.	700 HH, Step OD: 692 HH	Step length: 19.4
6	Inside Diameter	Drg. No.	600.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 HH / 12.5 x 8 x 7 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		645 HH	Tapping No of holes: 12 Back Side
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 22.3 HH Tapping Depth: 65 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 18/1/25

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° Ravi 132
2	External Relief Dia	4.5 HH	outside (3-3)		Inner			
3	External Relief Depth		18 HH		14 HH			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		18	1	25			

### Inspected By (Sign) & Date

Ravi 18/1/25

Satyam 18/1/25

Reviewed by (Engineer-CNC)

Manager-QA