



# 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)

9054

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13957	40/50/66
2	Machined By		V.T.L H/C Shop	Dy. No. 1.3.0.609
3	Pallet Die No.		14009 (B.O) H/C	Rev = 03
4	Die Category	Drg. No.	H. Jamba	
5	Out Side Diameter	Drg. No.	680.7 H/C	Step OD = 692.7 H/C Tapper = 8°
6	Inside Diameter	Drg. No.	546.12 H/C	Step length = 31 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut = 2.5 H/C
8	Grooves as per Drawing	Drg. No.	32 + 7 + 9.2 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	32 + 7 + 9.2 H/C (408) H/C	
10	Drilling Area Surface Smoothness		ok	Face side step 2 H/C Dark Blue Side
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 H/C	Tapping H.C. of Holes = 2 Both side
13	Tapping Hole Diameter		H16 Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.2 H/C	Tapping Depth = 31.6 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 23/1/25

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 Box

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H/C / 7.3 H/C	6.5 H/C	All Rows = 26 H/C					
3	External Relief Depth		7.3 H/C	All Rows = 16 H/C					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Romace					
6	Material Sent For Hardening On Date		23	1	25				

### Inspected By (Sign) & Date

Ravi 23/1/25

Satyam 23/1/25

Reviewed by (Engineer-CNC)

Manager-QA