



# 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.		9756	50/55
2	Machined By		V.T.L n/c Shop	Drill No. 1350, 355
3	Pallet Die No.		10396(4.0) H4	Revised
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 H4 Step OD, 612 H4	Step length 10mm
6	Inside Diameter	Drg. No.	520.12 H4	
7	Width of Pellet Die	Drg. No.	186 H4	
8	Grooves as per Drawing	Drg. No.	13x8x3 H4   13x8x3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of holes - 12 Both side
12	Tapping PCD		565 H4	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4 H4 Tapping Depth - 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/6/23

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							Ravi 17/6/23
2	External Relief Dia	4.5 H4	Outside (3-3)		Inner				
3	External Relief Depth		13 H4		5 H4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		17	6	23				

Inspected By (Sign) & Date

Ravi 17/6/23

Reviewed by (Engineer-CNC)

Manager-QA