



# 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.		10113 to 10187 to 10937	30/5/66
2	Machined By		N.T.L. H/c Shop	Drg No. 1130269
3	Pallet Die No.		10756 (6.0)H	Rev 2.01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H Step 602 693 H	Step length 31 H
6	Inside Diameter	Drg. No.	548.12 H	Tapper 8
7	Width of Pellet Die	Drg. No.	195 H	Under cut = 2.5 H
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H   32 x 8 x 8	(4 x 8) H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Fore side step 8 H
10	Drilling Area Surface Smoothness		ok	Back Both side
11	Tapping Operator		H/c Shop	Tapping No.
12	Tapping PCD		619 H	Holes 4
13	Tapping Hole Diameter		M16 ± Check by M16 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 H	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Pasi 2/9/23

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					Counter 30°
2	External Relief Dia	6.5 H   7.0 H	6.5 H All Lines	7.0 H All Lines			Law = 12
3	External Relief Depth		0.6 H	1.6 H			
4	Inspection Done Before Hardening By (Name)		Pasi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		2	9	23		

Inspected By (Sign) & Date Pasi 2/9/23

Reviewed by (Engineer-CNC)

Manager-QA