



# 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.		10159	49/71
2	Machined By		V.T.L n/c Shop	Marking = 48/70
3	Pallet Die No.		10767 (4.0) H4	Drg No. 1.202.12402 12008
4	Die Category	Drg. No.	S. Jumbo	Rev: 02
5	Out Side Diameter	Drg. No.	1288.9 H4	Step OD = 1288.9 H4
6	Inside Diameter	Drg. No.	1145.1 H4	Step length = 28 H4
7	Width of Pellet Die	Drg. No.	388.5 H4	
8	Grooves as per Drawing	Drg. No.	26x6x13 H4 / 26x6x13	
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 = 20 Both Side
12	Tapping PCD		1210 H4	
13	Tapping Hole Diameter		M24 = Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.4 H4	Tapping Depth = 31.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/9/23

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 - 2 Hole Closed

Note : Mark the defective holes/ Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK								Row = 56
2	External Relief Dia	4.8 H4	outside (4-4)		inner					
3	External Relief Depth		30 H4		22 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		6	9	23					

Inspected By (Sign) & Date

Ravi 6/9/23

Reviewed by (Engineer-CNC)

Manager-QA