



# 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.		10503	22/32/66
2	Machined By		V.T.L. N/C Shop	24/34/66
3	Pallet Die No.		10891 (6.0) H/H	Drill Hole I.S.D. 6.0
4	Die Category	Drg. No.	H. Jumbo	Row 201
5	Out Side Diameter	Drg. No.	680.69 H/H	Step OD = 699.8 H/H
6	Inside Diameter	Drg. No.	548.12 H/H	Tabber = 8"
7	Width of Pellet Die	Drg. No.	195 H/H	Step length = 31
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/H	Under cut = 2.5 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Fore Side Step 2 H/H Back Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping H. of Holes = 4 Both Side
12	Tapping PCD		619 H/H	
13	Tapping Hole Diameter		N/C. Check by N/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.4 H/H	Tapping Depth = 31.8
16	Perpendicularity of Tapped Hole		yes	(B)
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 11/10/23

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

	OK	Ist Pad	IInd Pad	Counter = 30°
1	Counter Sinking Depth & Finish			Row 212
2	External Relief Dia	6.5 H/H   7.0 H/H	6.5 H/H   7.0 H/H	
3	External Relief Depth	4.4 H/H   3.4 H/H	4.8 H/H   3.8 H/H	
4	Inspection Done Before Hardening By (Name)	Ravi		
5	Material Sent For Hardening By (Name)	Lark Furnace		
6	Material Sent For Hardening On Date	11	10	23

### Inspected By (Sign) & Date

Ravi 11/10/23

Reviewed by (Engineer-CNC)

Sats 11/10/23

Manager-QA