



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02  
 Form No. CNC/QA/FM/02  
 Rev. No. 01  
 Rev. Date 31-07-2013

6326

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10410	38/48/65.5
3	Pallet Die No.		V.T.L. H/c Shop	Dy. No. 1.S.D. 90.9
4	Die Category	Drg. No.	11154 (8.0) H4	Rev. 00
5	Out Side Diameter	Drg. No.	55570	
6	Inside Diameter	Drg. No.	641.7 H4 / Step 00 = 659.3 H4	Tapber = 8°
7	Width of Pellet Die	Drg. No.	508.8 H4 / Step 10 = 539.7 / 533.3 H4	Step length = 3.9
8	Grooves as per Drawing	Drg. No.	17.5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	94.25 H4 / 30.21 x 9 H4	Face side Step 0.5
10	Drilling Area Surface Smoothness		OK	Dist
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No. of holes = 4
13	Tapping Hole Diameter		574 H4	
14	Tapping On Second Side	Half pitch of 1st side	M16: Check by M16 Bolt	
15	Tapping Hole Depth		One Side Tapping and Und Side Slot	
16	Perpendicularity of Tapped Hole		Drill Depth = 30.4 H4	Tapping Depth = 28.7
17	Visual Inspection Before Gun Drilling		yes OK	

### Inspected By (Sign) & Date

Ravi 27/07/23

1	As per programme no.			4 Slot
2	Gun Drilling Work Completed On			51.3 H4 Long
3	Hole Finish In Gun Drilling	Marked	OK	28.1 H4 Depth
4	Defective Holes (If Any)		No	15.1 H4 Deep

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

1	Counter Sinking Depth & Finish	OK						Rev 08
2	External Relief Dia	8.5 H4 / 9.5 H4	8.5 H4 All Line	9.5 H4 All Line				
3	External Relief Depth		27.5 H4	17.5 H4				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ferrace
6	Material Sent For Hardening On Date		27	10	23			

### Inspected By (Sign) & Date

Ravi 27/07/23

Reviewed by (Engineer-CNC)

Manager-QA