



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10131	18/28/65.5
2	Machined By		N.T.L n/c Shop	20/65.5
3	Pallet Die No.		11162 (G.O) n/c	Drg No. 1.8.02 871
4	Die Category	Drg. No.	N.Yumbo	Rev: 01
5	Out Side Diameter	Drg. No.	711 n/c / Step OD = 725 n/c	Step length 234 n/c
6	Inside Diameter	Drg. No.	580112 n/c	Tapper 5°
7	Width of Pellet Die	Drg. No.	193 n/c	Wden cut 24.8 n/c
8	Grooves as per Drawing	Drg. No.	30.5 x 5 x 6 n/c (30.5 x 5 x 6 n/c)	(4 x 6) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step 1 n/c
10	Drilling Area Surface Smoothness		ok	Back Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		650 n/c	Tapping No of
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Holes: 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth: 35.6 n/c	Tapping Depth: 34 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/11/23

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

Counter: 30°

1	Counter Sinking Depth & Finish	ok	1st Pad 7.3 n/c	2nd Pad 7.5 n/c	Rows: 12
2	External Relief Dia	6.5 n/c / 7.3 n/c / 7.5 n/c	6.5 n/c	7.3 n/c	
3	External Relief Depth		47.5 n/c	37.5 n/c	45.5 n/c
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Forncare		
6	Material Sent For Hardening On Date		1	11	23

Inspected By (Sign) & Date

Ravi 11/11/23

Reviewed by (Engineer-CNC)

Manager-QA