



# 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.		10528	19/06
2	Machined By		V. T. L. NLC Shop	Dry No. 1.3.0.609
3	Pallet Die No.		10894 (6.0) H	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H, Step OD: 693 H	Tabber: 8°
6	Inside Diameter	Drg. No.	548.12 H	Step length: 31 H
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 7 x 8 H	(4 x 8) H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side step 5 H Back Side
11	Tapping Operator		NLC Shop	Deep
12	Tapping PCD		619 H	Tapping No. of holes: 4
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	Back 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 H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 31/11/23	
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				
1	Counter Sinking Depth & Finish	OK		Counter = 3° Low: 12
2	External Relief Dia	7.5 H	7.5 H All Lines	
3	External Relief Depth		4.7 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		3 11 23	
Inspected By (Sign) & Date			Ravi 31/11/23	

Reviewed by (Engineer-CNC)

Manager-QA