



# 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.		10417	33166
2	Machined By		V.T.L. NLC Shop	Drg No. LB.02.809
3	Pallet Die No.		11193 (G.O) H.H.	Row 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	Ø80.69 H.H. Step OD: 89.8 H.H. Tapper = 8°	
6	Inside Diameter	Drg. No.	54.12 H.H.	Step length = 31 H.H.
7	Width of Pellet Die	Drg. No.	195 H.H.	Under cut = 2.5 H.H.
8	Grooves as per Drawing	Drg. No.	32+7+8 H.H.   32+7+8 H.H.	(4+8) H.H.
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Fore side step 2 H.H.
10	Drilling Area Surface Smoothness		OK	Back Both Side
11	Tapping Operator		NLC Shop	Tapping No. of holes = 4
12	Tapping PCD		619 H.H.	Both Side
13	Tapping Hole Diameter		MIG: Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.4 H.H.	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 15/11/23

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								
2	External Relief Dia	7.5 H.H.	7.5 H.H. All lines							Row 12
3	External Relief Depth		33 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		15	11	23					

### Inspected By (Sign) & Date

Ravi 15/11/23

*[Signature]*  
15/11/23

Reviewed by (Engineer-CNC)

Manager-QA