



# 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)

6450

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10417	33/66
2	Machined By		V.T.L. n/c Shop	Drg No. 180.809
3	Pallet Die No.		11194 (B.O) n/c	Row 01
4	Die Category	Drg. No.	N. Jumbo n/c	
5	Out Side Diameter	Drg. No.	680.69 n/c Step 00 = 693.8 n/c	Tappers 8°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 31.7
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32.7 x 8 n/c   32.7 x 8 n/c	(4 x 8) n/c step 3 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Back Side
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 4
12	Tapping PCD		619 n/c	Back Side
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 n/c Tapping Depth 31.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/11/23

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

Counters 30

1	Counter Sinking Depth & Finish	OK							Row 212
2	External Relief Dia	7.5 n/c	7.5 n/c	All Lines					
3	External Relief Depth			33 n/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		18	11	23				

Inspected By (Sign) & Date

Ravi 18/11/23

Reviewed by (Engineer-CNC)  
Soham  
18/11/23

Manager-QA