



# 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.		10739 ✓	114/55
2	Machined By		N. T. L. Shop	Dwg No. 1.2.02 453
3	Pallet Die No.		10778 (21.0) ✓	Rev. 00
4	Die Category	Drg. No.	J&D	
5	Out Side Diameter	Drg. No.	740 H4 / Step 00, 743	5 H4 Tappers 16
6	Inside Diameter	Drg. No.	630.12 H4	Step length 16.3 H4
7	Width of Pellet Die	Drg. No.	290 H4	Under cut 1.75
8	Grooves as per Drawing	Drg. No.	15x8x5 H4   15x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N.C. Shop	Tapping No of holes = 16 Both side
12	Tapping PCD		685 H4	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H4 Tapping Depth 18.8 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 25/11/23

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							Ravi 253
2	External Relief Dia	4.5 H4	outside (3-3)		Inner				
3	External Relief Depth		19 H4		11 H4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		25	11	23				

### Inspected By (Sign) & Date

Ravi 25/11/23

Satyam 25/11/23

Reviewed by (Engineer-CNC)

Manager-QA