



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

5743

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.		9870	45/50
2	Machined By		V.T.L H/c Shop	406
3	Pallet Die No.		10006 (32) H/H	Rev: 00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	680 H/H	Step OD = 683 H/H
6	Inside Diameter	Drg. No.	520 H/H	Step length = 12 H/H
7	Width of Pellet Die	Drg. No.	222 H/H	Step length = 18 H/H
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H	Under cut = 1.5 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		585 H/H	Tapping No. of holes: 12 Both side
13	Tapping Hole Diameter		M20x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H/H	Tapping Depth = 8.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/7/23	
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	
<b>Note :</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		ok	Ravi 37
2	External Relief Dia		3.8 H/H	
3	External Relief Depth		12 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		4 7 23	
Inspected By (Sign) & Date			Ravi 4/7/23	

Reviewed by (Engineer-CNC)

Manager-QA