



# 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.		11009	53/58
2	Machined By		V.T.L n/c Shop	Drg No. 1.3.0.950
3	Pallet Die No.		11567 (3.8)H	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	✓
5	Out Side Diameter	Drg. No.	716 H Step OD = 692.8 H	Tabber = 12°
6	Inside Diameter	Drg. No.	600.12 H	Step length = 19.8
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 H / 12 x 8 x 7 H	
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 = 12 Both Side
12	Tapping PCD		640 H	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3 H Tapping Depth = 18.8 H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 10/1/24

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

Coordinate = 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.3 H	outside (3-3)		Inner					
3	External Relief Depth	✓	12 H		5 H					
4	Inspection Done Before Hardening By (Name)		✓	Ravi						
5	Material Sent For Hardening By (Name)		Lark Forware							
6	Material Sent For Hardening On Date		10	1	24					

**Inspected By (Sign) & Date**

Ravi 10/1/24

Reviewed by (Engineer-CNC)

Manager-QA