



# 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.		10981	40/50/70
2	Machined By		V.T.L. H/c Shop	Drg No. 13.02.977
3	Pallet Die No.		10577 (3.0) H/c	Rev 203
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 H/c Step 00 + 697.3 H/c	Step length 38.5
6	Inside Diameter	Drg. No.	548.12 H/c	Tapper 5
7	Width of Pellet Die	Drg. No.	215 H/c	Width out 1.79 H/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 H/c / 29.5 x 10 x 8 H/c (673) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. 7
12	Tapping PCD		618 H/c	of holes 2
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32.3 H/c Tapping Depth 30 H/c	
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

1	Counter Sinking Depth & Finish	ok					Counters 30°
2	External Relief Dia	8.5 H/c / 9.0 H/c	8.5 H/c All Lines	9.0 H/c All Lines			Low = 12
3	External Relief Depth		30 H/c	20 H/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		10	1	24		

Inspected By (Sign) & Date Ravi 10/1/24

Reviewed by (Engineer-CNC)

Manager-QA