



# 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.		11031	36/50
2	Machined By		V.T.L. n/c Shop	Drg No. 18.02344
3	Pallet Die No.		8890 (30) n/c	Rev. no
4	Die Category	Drg. No.	NJ&D	✓
5	Out Side Diameter	Drg. No.	700 n/c	Step length = 19.5
6	Inside Diameter	Drg. No.	600.12 n/c	✓
7	Width of Pellet Die	Drg. No.	265 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 n/c / 15x8x7 n/c	
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		640 n/c	
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 = 21.4 n/c	Tapping Depth = 19 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/1/24

- 1 As per programme no.
- 2 Gun Drilling Work Completed On
- 3 Hole Finish In Gun Drilling
- 4 Defective Holes (If Any)

Marked

OK

No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 n/c	outside (3-3)		Inner				Ravi 24
3	External Relief Depth		20 n/c		14 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								11 1 24

Inspected By (Sign) & Date

Ravi 11/1/24