



# 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.		10871	40/45
2	Machined By		N.T.L. N/C Shop	Drg No. 1-3.0-541
3	Pallet Die No.		10673 (6.0) H/H	Rev 2-00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 H/H, Step OD = 395 H/H	Step length = 4.5
6	Inside Diameter	Drg. No.	320.12 H/H	
7	Width of Pellet Die	Drg. No.	148 H/H	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 + 2 H/H   15.5 x 7 + 2 H/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: 8 Both Side
12	Tapping PCD		355 H/H	
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21.4 H/H	Tapping Depth = 19 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 12/1/24

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

Counter 60°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	6.5 H/H	Outside (2.2)		Innen					
3	External Relief Depth		11 H/H		5 H/H					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Purchase					
6	Material Sent For Hardening On Date			12	1	24				

Inspected By (Sign) & Date

Ravi 12/1/24

Sahar 12/01/24