



# 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.		11059	28/36/55
2	Machined By		V.T.L. n/c Shop	Dy. n/c L.S. 6.407
3	Pallet Die No.		11570 (5.0) n/c	Recess
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c, Step OD = 692.8 n/c	Tappers 12°
6	Inside Diameter	Drg. No.	600.14 n/c   600.2 n/c (B)	Step length = 19.8
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c   12 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes = 12 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 13/1/24

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	5.5 n/c   6.0 n/c	5.5 n/c All Lines	6.0 n/c All Lines						
3	External Relief Depth		27 n/c	19 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		13	1	24					

**Inspected By (Sign) & Date**

Ravi 13/1/24

Reviewed by (Engineer-CNC)  
Satyam 13/1/24

Manager-QA