



# 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.		10880	31/07/13
2	Machined By		V.T.L. N/C Shop	876
3	Pallet Die No.		11417 (3.0) H/H	Round
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	806 H/H	Step OD = 642 H/H
6	Inside Diameter	Drg. No.	520.14 H/H	Tapper = 10°
7	Width of Pellet Die	Drg. No.	238 H/H	Step length = 29 H/H
8	Grooves as per Drawing	Drg. No.	20x10x4 H/H / 20x10x4 H/H	Under cut = 13 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		590 H/H	Tapping no of holes = 8 Back Side
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 = 28.3 H/H	Tapping Depth = 25.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/1/24

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

Count = 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 H/H / 4.0 H/H	3.5 H/H All Lines	4.0 H/H All Lines					Round 37
3	External Relief Depth	/	12 H/H	9 H/H					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		18	1	24				

Inspected By (Sign) & Date

Ravi 18/1/24

18/01/24