



# 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.			
2	Machined By		11117	28/50
3	Pallet Die No.		V.T.L. H/C Shop	Drg No. 13.0.392
4	Die Category	Drg. No.	11698(4.0)H4	Rev. 2.000
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 H4, Step 00. 500 H4	Step length 18 H4
7	Width of Pellet Die	Drg. No.	420.12 H4	Tappe = 10°
8	Grooves as per Drawing	Drg. No.	158 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	12+8+3 H4 / 12+8+3 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No of holes = 8 Both Side
13	Tapping Hole Diameter		455 H4	
14	Tapping On Second Side	Half pitch of 1st side	<del>455</del> H20 = Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth. 19.9 H4 Tapping Depth. 17 H4	
17	Visual Inspection Before Gun Drilling		Yes ok	

**Inspected By (Sign) & Date**

Ravi 25/1/24

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	4.5 H4	outside 2-2		inner				
3	External Relief Depth		16 H4		12 H4				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		25		1	24			

**Inspected By (Sign) & Date**

Ravi 25/1/24

25/1/24

Reviewed by (Engineer-CNC)

Manager-QA