



# 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

6860

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11143	28/33/66
3	Pallet Die No.		V.T.L. n/c Shop	26/31/66
4	Die Category	Drg. No.	11478 (8.0) n/c	Drg No. L.S.D. 609
5	Out Side Diameter	Drg. No.	M. Jumbo	Revised
6	Inside Diameter	Drg. No.	68.69 n/c Step OD, 69.8 n/c Tapper	
7	Width of Pellet Die	Drg. No.	548.12 n/c	Step length 31 n/c
8	Grooves as per Drawing	Drg. No.	195 n/c	Under cut 2.4 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x8 n/c 32x7x8 n/c (4x2)	
10	Drilling Area Surface Smoothness		ok	Face side step
11	Tapping Operator		ok	Back Side
12	Tapping PCD		n/c Shop	Tapping no of holes 4
13	Tapping Hole Diameter		619 n/c	Back Side
14	Tapping On Second Side	Half pitch of 1st side	MIG: Check by MIG Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 33.4 n/c Tapping Depth 31.2	
17	Visual Inspection Before Gun Drilling		yes	
			ok	

### Inspected By (Sign) & Date

Ravi 29/1/24

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

1	Counter Sinking Depth & Finish	ok				Counter, 30°
2	External Relief Dia	8.5 n/c / 9.0 n/c	8.5 n/c = 32 n/c	8.5 n/c = 40 n/c		Rep. 10
3	External Relief Depth		9.0 n/c = 33 n/c	9.0 n/c = 35 n/c		
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Purvace			
6	Material Sent For Hardening On Date		29	1	24	

### Inspected By (Sign) & Date

Ravi 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA