



# 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

6917

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11217	36/40
2	Machined By		V.T.L.H/c Shop	Drg. No. 1.2.02.15063
3	Pallet Die No.		10960 (H.O.)H/c	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm. H/c, Step OD = 498.38	Tapping 12"
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 17.8
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12+8+3 H/c   12+8+3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes: 8 Both side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.8 H/c	Tapping Depth 17.2 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 6/8/24

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					Counters 60
2	External Relief Dia	4.5 H/c	Outside (2-2)	Inner			Rev 2.20
3	External Relief Depth		8 H/c	4 H/c			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Ramare
6	Material Sent For Hardening On Date		6	8	24		

### Inspected By (Sign) & Date

Ravi 6/8/24

Reviewed by (Engineer-CNC)

Manager-QA