



# 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.		11077	60/66
2	Machined By		V.T.L. n/c Shop	58/66
3	Pallet Die No.		11487 (10.0) n/c	Dykes 18.0.69
4	Die Category	Drg. No.	H. Jombo	Revised
5	Out Side Diameter	Drg. No.	680.69 n/c, Step OD = 698.8 n/c	Tapper = 8°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length = 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.4 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c   32 x 7 x 8 n/c (4 x 8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 8 n/c
10	Drilling Area Surface Smoothness		ok	Deep Back Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping Ho
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	of Hole = 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth = 33.4 n/c	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/8/24

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

Counter, 60

1	Counter Sinking Depth & Finish	ok							Counter, 60
2	External Relief Dia	11.0 n/c	1st Pad All Rows 6 n/c	2nd Pad All Rows 10 n/c					Row = 8
3	External Relief Depth	/							
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	2	24				

Inspected By (Sign) & Date

Ravi 13/8/24

Reviewed by (Engineer-CNC)

Manager-QA