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# 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.		11295	35/55
2	Machined By		V. T. L. H/c Shop	Dy. No. 1.3.D. 457
3	Pallet Die No.		11941 (3.8) H/c	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 H/c	Step 00 = 800 H/c
6	Inside Diameter	Drg. No.	660.12 H/c	Step length = 6 H/c
7	Width of Pellet Die	Drg. No.	316 H/c	Under cut = 15 H/c
8	Grooves as per Drawing	Drg. No.	20x8x7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	20x8x7.5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		725 H/c	
13	Tapping Hole Diameter		M2 = Check by New Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25.8 H/c	Tapping Depth = 3.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 19/8/24

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	4.3 H/c	0						Counter = 60° Ravi = 48
2	External Relief Dia	4.3 H/c	Opp side (3-3)		Inner				
3	External Relief Depth		23 H/c		20 H/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			19	8	24			

**Inspected By (Sign) & Date**

Ravi 19/8/24

Reviewed by (Engineer-CNC)  
 Satish 19/8/24

Manager-QA