



# 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.		11351	36/46/55
2	Machined By		V.T.L n/c Shop	Dry No. 19014924
3	Pallet Die No.		11358 (4.0) H4	Rev 2.00
4	Die Category	Drg. No.	Ext. 29 wide	
5	Out Side Diameter	Drg. No.	630 H4	
6	Inside Diameter	Drg. No.	612 H4	Step length 19.4
7	Width of Pellet Die	Drg. No.	590.12 H4	
8	Grooves as per Drawing	Drg. No.	222.1 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H4 / 13x8x5 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 H4	Tapping No. of holes 12
13	Tapping Hole Diameter		M202 Check by M20 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 H4	Tapping Depth = 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 26/8/24

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					Counter = 60°
2	External Relief Dia	4.5 H4 / 5.0 H4	4.5 H4 All Rows	5.0 H4 All Rows			Row = 31
3	External Relief Depth		19 H4	9 H4			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Porrao				
6	Material Sent For Hardening On Date		26	2	24		
Inspected By (Sign) & Date			Ravi 26/8/24				

Reviewed by (Engineer-CNC)

Manager-QA