



# 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.		11285	50/65.5
2	Machined By		V.T.L. n/c Shop	Drg No. 1-3.D2902
3	Pallet Die No.		11156 (10.0) n/c	Rev 200
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	640.3 n/c, Step OD = 641.7 n/c / 652.3 n/c	
6	Inside Diameter	Drg. No.	508.8 n/c / 523.3 n/c / 539.7 n/c	Tapper. 8°
7	Width of Pellet Die	Drg. No.	174.8 n/c	Step length = 32 n/c
8	Grooves as per Drawing	Drg. No.	29.8 x 21 n/c / 9 x 25 n/c	Wd = 0.7
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of Holes = 4
12	Tapping PCD		574 n/c	
13	Tapping Hole Diameter		M16. Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 1st Side 4 Slot	
15	Tapping Hole Depth		Drill Depth = 31 n/c Tapping Depth = 28.4 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 29/7/24

1	As per programme no.			4 Slot 51.5 n/c Long 28 n/c wide 15 n/c Deep
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							
2	External Relief Dia	11.0 n/c	All Rows						
3	External Relief Depth		15.5 n/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		29	2	24				

### Inspected By (Sign) & Date

Ravi 29/7/24

Reviewed by (Engineer-CNC)

Manager-QA