



# 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.		9901	44/55
2	Machined By		V.T. L. n/c Shop	Dry Hole 1.20-639
3	Pallet Die No.		9411 (8.0) mm	Rev 2.00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	630 mm Step OD = 634 mm	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 mm	Step length = 18 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm   13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	Tapping No of Holes = 12 Both Side
13	Tapping Hole Diameter		M20	
14	Tapping On Second Side	Half pitch of 1st side	OK Check by M20 Bolt	
15	Tapping Hole Depth		Drill Depth = 20.5 mm	
16	Perpendicularity of Tapped Hole		yes	Tapping Depth = 18.8
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 15/7/23	
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	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	OK		Row = 18
2	External Relief Dia	8.5 mm	Outside (2-3)	
3	External Relief Depth		19 mm	Inner 11 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		15 7 23	
Inspected By (Sign) & Date			Ravi 15/7/23	

Reviewed by (Engineer-CNC)

Manager-QA

Tanuj 15/7/23