



# 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.		11373	27/40
2	Machined By		V.T.I. H/O Shop	By Mr. Lakh...
3	Pallet Die No.		10988 (2.0) H/H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500.1 H/H Step OD = 491.1 H/H	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12 H/H / 420.14 H/H (A)	
7	Width of Pellet Die	Drg. No.	158.1 H/H	
8	Grooves as per Drawing	Drg. No.	12+8+3 H/H / 12+8+3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping No. of holes, 8 Both Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 19 H/H Tapping Depth: 17 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 2/8/24

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	3.5 H/H	Outside (2-2)	Inner			Rows = 24
3	External Relief Depth		16 H/H	13 H/H			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		2	3	24		

Inspected By (Sign) & Date Ravi 2/8/24

Reviewed by (Engineer-CNC) [Signature]

Manager-QA