



# 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.		10826,	34/50
2	Machined By		V.T.L H/C Shop	Dy. No. L.E.G. 12501
3	Pallet Die No.		9974 (3.0) NY	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 NY / Step 002 692.8 NY	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 NY / 600.14 NY (A)	Step length 19.2
7	Width of Pellet Die	Drg. No.	222 NY	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 NY / 12 x 8 x 7 NY	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No of holes 12 Both Side
12	Tapping PCD		640 NY	
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 81 NY Tapping	Depth 18.8 NY
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/3/24

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 - 2 Hole Calused

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK					Counter 6° Ravi 39
2	External Relief Dia	3.5 NY	Outside (3-3)	Inner			
3	External Relief Depth	/	22 NY	16 NY			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		4	3	24		

Inspected By (Sign) & Date

Ravi 4/3/24

Saty 4/3/24  
Reviewed by (Engineer-CNC)

Manager-QA