



# 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.		11450/	45/45/
2	Machined By		V.T.L H/c Shop	Drg. No. L.S.O. 507
3	Pallet Die No.		11894 (4.0) H/H	Recess
4	Die Category	Drg. No.	Extraxide	
5	Out Side Diameter	Drg. No.	610 H/H, Step on - 623.9 H/H	Tappet. 12/
6	Inside Diameter	Drg. No.	580.14 H/H	Step length 18 H/H
7	Width of Pellet Die	Drg. No.	222 H/H	Under cot. 7 H/H
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H   13x8x5 H/H	
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 Bottom Side
12	Tapping PCD		565 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 = 20.8 H/H	Tapping Depth = 18.7 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 13/3/24

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

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

Counters G<sup>o</sup>

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H/H	outside (3-3)		Inner				
3	External Relief Depth		7 H/H		Mill				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Forge				
6	Material Sent For Hardening On Date		13	3	24				

### Inspected By (Sign) & Date

Ravi 13/3/24

Reviewed by (Engineer-CNC)

Manager-QA