



# 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.		11324	4.0/6.0/6.6
2	Machined By		V. T. L. H/c Shop	Drg. No. I.S.O. 809
3	Pallet Die No.		11926(6.0) H/c	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c Step 02, 692 H/c	Tap hole 8°
6	Inside Diameter	Drg. No.	548.14 H/c	Step length 3 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c   32 x 7 x 8 H/c (4 x 8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step 3 H/c
10	Drilling Area Surface Smoothness		OK	Back Side
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		619 H/c	of Holes: 4
13	Tapping Hole Diameter		H/c - Check by H/c Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 33.6 H/c	Tapping Depth: 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Rasi 15/3/24

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

1	Counter Sinking Depth & Finish	OK					Counter 30
2	External Relief Dia	6.5 H/c   7.0 H/c	6.5 H/c All Rows	7.0 H/c All Rows			Row: 12
3	External Relief Depth		28 H/c	8 H/c			
4	Inspection Done Before Hardening By (Name)		Rasi				
5	Material Sent For Hardening By (Name)		Lark For name				
6	Material Sent For Hardening On Date		15	3	24		
Inspected By (Sign) & Date			Rasi 15/3/24				

Reviewed by (Engineer-CNC)

Manager-QA