



# 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.		11405	36/45
2	Machined By		V.T.L. n/c Shop	Dy. No. 6.8.92.302
3	Pallet Die No.		11138 (6.0) n/c	Rev. 100
4	Die Category	Drg. No.	SCW	
5	Out Side Diameter	Drg. No.	510 n/c	Step 00 - 49 n/c
6	Inside Diameter	Drg. No.	420.14 n/c	Step length 16.4
7	Width of Pellet Die	Drg. No.	173 n/c	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		455 n/c	Tapping at hole. 8 Both side
13	Tapping Hole Diameter		03/4" = Check by 03/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/8/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		N-

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

1	Counter Sinking Depth & Finish	ok						Counter 60 Row 2 12
2	External Relief Dia	0.5 n/c	outside 0.25		inner			
3	External Relief Depth		15 n/c		9 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark furnace
6	Material Sent For Hardening On Date		18	3	24			

Inspected By (Sign) & Date

Ravi 18/8/24

Reviewed by (Engineer-CNC)

Manager-QA