



# 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.		11520	45/45
2	Machined By		V. T. L. N/A Shop	Drill No. L.E.C. 15430
3	Pallet Die No.		11969 (3.0) NY	Row 00
4	Die Category	Drg. No.	2ed side	
5	Out Side Diameter	Drg. No.	610 NY, Step OD = 612 NY	Step length = 20 NY
6	Inside Diameter	Drg. No.	520.14 NY	19.4 NY
7	Width of Pellet Die	Drg. No.	222 NY	Under cut = 1 NY
8	Grooves as per Drawing	Drg. No.	13x8x5 NY / 13x8x5 NY	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No of holes = 12 Beta Side
12	Tapping PCD		565 NY	
13	Tapping Hole Diameter		N/A = Check by N/A Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.7 NY	Tapping Depth = 18.2 NY
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Rasi 18/3/24

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 60
2	External Relief Dia	3.5 NY	Outside (3-3)		Inner				
3	External Relief Depth		4 NY		Nil				
4	Inspection Done Before Hardening By (Name)								Rasi
5	Material Sent For Hardening By (Name)								Lark Forge
6	Material Sent For Hardening On Date			18	3	24			

Inspected By (Sign) & Date Rasi 18/3/24

Reviewed by (Engineer-CNC) [Signature] 18/3/24

Manager-QA