



# 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.		10131	20/35/65.5
2	Machined By		V.T.L.H/C Shop	22/65.5
3	Pallet Die No.		11161 (6.0) H/C	Dry Holes (2.0) 371
4	Die Category	Drg. No.	H. Jumbo	Rev. 01
5	Out Side Diameter	Drg. No.	711 H/C Step 00 = 704.8 H/C	Tabbes = 5"
6	Inside Diameter	Drg. No.	580.12 H/C	Step length = 34 H/C
7	Width of Pellet Die	Drg. No.	193 H/C	Under cot = 4.1 H/C
8	Grooves as per Drawing	Drg. No.	31x4.5x6 H/C   31x4.5x6 H/C (4x6) H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Face Side Step 1 H/C Deep Both Side ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		650 H/C	[ Tapping No of holes = 4 Both Side ]
13	Tapping Hole Diameter		H16 Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 38 H/C Tapping Depth = 33.6 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 22/3/24

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

Counter = 30

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 H/C   7.5 H/C	Is Pad						
3	External Relief Depth		3.5 H/C All Rows = 45.5 H/C 4.5 H/C All Rows = 40.5 H/C						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Ray Trace						
6	Material Sent For Hardening On Date		22	3	24				

**Inspected By (Sign) & Date**

Ravi 22/3/24

Reviewed by (Engineer-CNC)

Manager-QA