



# 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

2171

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11528	50/50
2	Machined By		V.T.L. H/c Shop	Dy. H/c 1.8.02
3	Pallet Die No.		11400 (6.0) H/c	Rev. 00
4	Die Category	Drg. No.	59970	
5	Out Side Diameter	Drg. No.	621 H/c / Step 02 : 623.2 H/c	Tabber 12°
6	Inside Diameter	Drg. No.	520.14 H/c	Step length 14 H/c
7	Width of Pellet Die	Drg. No.	186 H/c	Lead ex. rate 14 H/c
8	Grooves as per Drawing	Drg. No.	9x10x3 H/c   9x10x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping H/c of Holes = 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 24 H/c	Tapping Depth 21.8 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 28/3/24

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 60

1	Counter Sinking Depth & Finish	OK							Row = 18
2	External Relief Dia	6.3 H/c	Op Side (3-3)		Inner				
3	External Relief Depth		4 H/c		Null				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			22	3	24			

### Inspected By (Sign) & Date

Ravi 28/3/24

Satyam 28/3/24

Reviewed by (Engineer-CNC)

Manager-QA