



# 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.		11530	33/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.2-45
3	Pallet Die No.		11526 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	720	
5	Out Side Diameter	Drg. No.	730 n/c / Step 00 = 743.4 n/c	Tapber, 10°
6	Inside Diameter	Drg. No.	630.12 n/c	Step length 23 n/c
7	Width of Pellet Die	Drg. No.	290 n/c	Under cut. 6.75 n/c
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c / 15x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 16 Bolt side
12	Tapping PCD		685 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
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 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/3/24

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° Form = 52
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner			
3	External Relief Depth		23 n/c		17 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		27	3	24			

### Inspected By (Sign) & Date

Ravi 27/3/24

Saty 27/3/24

Reviewed by (Engineer-CNC)

Manager-QA