



# 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.		11519	33/40
2	Machined By		V. T. L. H/C Shop	Drg No. 1-20215062
3	Pallet Die No.		11286(3.5)H	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H Step OD 498.8 H	Tabber 12°
6	Inside Diameter	Drg. No.	420.12 H	Step length 17.5 H
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H / 12x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H	Tapping H <sub>0</sub> of Hole = 8 Rate Side
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 19.8 H	Tapping Depth 17.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 21/3/24

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 = 6° Rev = 22
2	External Relief Dia	3.8 H	outside (2.2)		Inner			
3	External Relief Depth		10 H		7 H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		21	3	24			

### Inspected By (Sign) & Date

Ravi 21/3/24

Reviewed by (Engineer-CNC)

Manager-QA