



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

5609

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.		9843	22/45
2	Machined By		V.T.L. H/c Shop	Dr No. 1.3.0 = 652
3	Pallet Die No.		9841 (3.0) H/c	Rev 2.9
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	690 H/c Step 00 = 692.8 H/c	Tappers 12
6	Inside Diameter	Drg. No.	600.12 H/c	Step length, 19.8 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut = 1.5 H/c
8	Grooves as per Drawing	Drg. No.	12x10x7.4 H/c   12x10x7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth = 18.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date				
			Ravi 3/6/23	
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	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Rev 2.38
2	External Relief Dia	3.5 H/c	Outside (3.3)	Inner
3	External Relief Depth		26 H/c	23 H/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		3	6 23
Inspected By (Sign) & Date				
			Ravi 3/6/23	

Reviewed by (Engineer-CNC)

Manager-QA