



# 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.		11432	47/50
2	Machined By		V.T.L. H/c Shop	Drg No. 1802 403
3	Pallet Die No.		12269 (8.0) H/c	Rev. 05
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/c Step 00. 491 H/c	Step length 7.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158.1 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c   12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Hole 8 Bolt Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		ø3/4" = Check by ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 H/c Tapping Depth 17.2 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 2/4/24

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							
2	External Relief Dia	8.5 H/c	Outside (2-2)		Inner				
3	External Relief Depth		8 H/c		3 H/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Fornace
6	Material Sent For Hardening On Date			2	4	34			

**Inspected By (Sign) & Date**

Ravi 2/4/24

Ravi 2/4/24

Reviewed by (Engineer-CNC)

Manager-QA