



# 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.		11678	45/56/66
2	Machined By		V. T. L. n/c Shop	Drg No. 693
3	Pallet Die No.		12038 (80) n/c	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c, Step OD = 693 n/c	Tabber, 8
6	Inside Diameter	Drg. No.	548.12 n/c	Step length. 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32-7-8 n/c   32-7-8 n/c	4.8
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side 3+4 Back side 3+4
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		619 n/c	of holes. 4
13	Tapping Hole Diameter		MIG - Check by MIG Bolt	Back side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.8 n/c	Tapping Depth. 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 30/3/24

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 30
2	External Relief Dia	8.5 n/c   9.0 n/c	8.5 n/c	All Rows	9.0 n/c	All Rows	
3	External Relief Depth		2.0 n/c			1.0 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		30	3	24		

### Inspected By (Sign) & Date

Ravi 30/3/24

Reviewed by (Engineer-CNC)

Manager-QA