



# 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.		11571	50160
2	Machined By		V.T.L. H/c Shop	Dy. No. 1.8.02409
3	Pallet Die No.		12274 (4.0) H	Rev. 00
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	640 H, Step OD = 612 H, Step length = 17.4	
6	Inside Diameter	Drg. No.	520.14 H (A)	(A)
7	Width of Pellet Die	Drg. No.	186 H	
8	Grooves as per Drawing	Drg. No.	13x8x3 H   13x8x3 H	Face side step 1st Back Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of holes = 12
12	Tapping PCD		565 H	Back 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 = 20.8 H Tapping Depth = 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 4/4/24

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

1	Counter Sinking Depth & Finish	ok						Counter = 60
2	External Relief Dia	4.5 H	outside (3-3)		Inner			Raw 225
3	External Relief Depth		18 H		10 H			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Forcece
6	Material Sent For Hardening On Date		4	4	24			

Inspected By (Sign) & Date

Raw: 4/4/24

Reviewed by (Engineer-CNC)

Manager-QA