



# 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.		11640	32/38/45
2	Machined By		N. T. C. H/c Shop	Qty 40, 10, 20, 20
3	Pallet Die No.		11736 (3.5) H/c	Rev 2.00
4	Die Category	Drg. No.	N. Tamba	
5	Out Side Diameter	Drg. No.	690 H/c, Step 02 = 703 H/c	Tabber: 4°
6	Inside Diameter	Drg. No.	600.12 H/c	Step length: 23.5
7	Width of Pellet Die	Drg. No.	250 H/c	Under cut: 6.5 H/c
8	Grooves as per Drawing	Drg. No.	247579 H/c / 247579 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		655 H/c	
13	Tapping Hole Diameter		MIG - Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 25 H/c Tapping Depth: 23.8 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 9/4/24

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							Count ev. 60°
2	External Relief Dia	4.0 H/c / 4.5 H/c	4.0 H/c All Rows	4.5 H/c All Rows					
3	External Relief Depth		13 H/c	7 H/c					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark For case
6	Material Sent For Hardening On Date		9	4	24				

**Inspected By (Sign) & Date**

Ravi 9/4/24

Reviewed by (Engineer-CNC)

Manager-QA