



# 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.		11161	40/53
2	Machined By		V.T.L u/c Shop	Dr. No. 12.2-969
3	Pallet Die No.		12278 (8.0) mm	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	409.8 mm Step 00. 383.3 mm	Step length 11 mm
6	Inside Diameter	Drg. No.	304.12 mm	
7	Width of Pellet Die	Drg. No.	121 mm	
8	Grooves as per Drawing	Drg. No.	8.5 x 7 x 2 mm / 8.5 x 7 x 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of holes = 8 Both Side
12	Tapping PCD		350 mm	
13	Tapping Hole Diameter		M12 Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 mm Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 10/4/24

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 Cor. = 8
2	External Relief Dia	8.5 mm	outside (2-2)	Inner			
3	External Relief Depth		17 mm	13 mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark furnace
6	Material Sent For Hardening On Date		10	4	24		

### Inspected By (Sign) & Date

Ravi 10/4/24

Reviewed by (Engineer-CNC)

Manager-QA