



# 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.		11710	45/45
2	Machined By		V.T.L. n/c Shop	By H.O.L.S.D. 10/20
3	Pallet Die No.		11436 (3.0) H4	Pass
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	720 H4, Step OD, 743 H4	Tapping H4
6	Inside Diameter	Drg. No.	630.12 H4	Step length 22.5
7	Width of Pellet Die	Drg. No.	255 H4	Undercut 11.5 H4
8	Grooves as per Drawing	Drg. No.	22x8x7 H4 / 22x8x7 H4	
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 = 12 Both Side
12	Tapping PCD		685 H4	
13	Tapping Hole Diameter		M22 = Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 99 H4	Tapping Depth = 96.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/4/24

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° Lead = 42
2	External Relief Dia	3.5 H4	outside (3-3)		Inner				
3	External Relief Depth		4 H4		Null				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		15	4	24				

Inspected By (Sign) & Date

Ravi 15/4/24

Reviewed by (Engineer-CNC)  
Santosh 15/4/24

Manager-QA