



# 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.		9898	35/50/66 ✓
2	Machined By		V.T.L. n/c Shop	40/66 ✓
3	Pallet Die No.		10580(10.0) n/c	Drg. H. 2 L.S. D. 2 609
4	Die Category	Drg. No.	M. Jumbo	Rev. 201
5	Out Side Diameter	Drg. No.	680.69 n/c Step 002 693 n/c	Tapper = 8°
6	Inside Diameter	Drg. No.	548.14 n/c	Step Lengths 3 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Undercut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c   32 x 7 x 8 n/c	(4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 n/c
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 4
12	Tapping PCD		619 n/c	Both Side
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 33.4 n/c	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/7/23

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	1st Rad	11.0 n/c	2nd Rad	11.0 n/c	Counters 60
2	External Relief Dia	10.5 n/c   11.0 n/c	10.5 n/c	11.0 n/c	11.0 n/c		Rad = 8
3	External Relief Depth		31 n/c	16 n/c	26 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		19	7	23		

Inspected By (Sign) & Date

Ravi 19/7/23

Reviewed by (Engineer-CNC)

Manager-QA