



# 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	S.No.	Check Parameter	Specification	Observations	Remarks
	1	Work Order No.		11882	40/60
	2	Machined By		V.T.L. H/C Shop	Dry No. 1302584
	3	Pallet Die No.		12230 (4.0) H/C	Rev. 01
	4	Die Category	Drg. No.	Jumbo	
	5	Out Side Diameter	Drg. No.	780 H/C Step OD. 798 H/C	Tapper, 4°
	6	Inside Diameter	Drg. No.	660.12 H/C	Step length 25.5 H/C
	7	Width of Pellet Die	Drg. No.	324 H/C	Under Cut - 9 H/C
	8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H/C / 21.5 x 8 x 10 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 Botu Side
	12	Tapping PCD		725 H/C	
	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 - 31 H/C	Tapping Depth - 28.8 H/C
	16	Perpendicularity of Tapped Hole		yes	
	17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 7/5/24

1	As per programme no.				2 Slot 32.1 H/C width 8 H/C Deep Botu Side
2	Gun Drilling Work Completed On				
3	Hole Finish In Gun Drilling	Marked	ok		
4	Defective Holes (If Any)		No - 2 Hole Closed		

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok								Counter 60° Row 47
2	External Relief Dia	4.5 H/C	Outside (3-3)		Inner					
3	External Relief Depth		24 H/C		20 H/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			7	5	24				

Inspected By (Sign) & Date Ravi 7/5/24

Reviewed by (Engineer-CNC) Satyam 7/5/24

Manager-QA