



# 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.		12123	40/47
2	Machined By		V. T. G. H/a Shop	Drg No. 1858
3	Pallet Die No.		12588 (4.0) H/a	Rev 2.00
4	Die Category	Drg. No.	Backside	
5	Out Side Diameter	Drg. No.	614 H/a, Step OD: 691.5 H/a	Tappe, 12°
6	Inside Diameter	Drg. No.	590.14 H/a	Step length: 91.5
7	Width of Pellet Die	Drg. No.	222 H/a	Under cut: 3.75 H/a
8	Grooves as per Drawing	Drg. No.	13x8x5 H/a	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/a Shop	
12	Tapping PCD		565 H/a	Tapping H/a of holes 12 Back Side
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: 20.6 H/a	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 10/6/24	
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	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish		ok	Counter: 60° Ravi 31
2	External Relief Dia		4.5 H/a	All Rows
3	External Relief Depth		7 H/a	
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 6 24	
Inspected By (Sign) & Date			Ravi 10/6/24	

Reviewed by (Engineer-CNC)  
Santosh 10/6/24

Manager-QA