



# 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.		9671	40/50/69
2	Machined By		N.T.C. N/C Shop	Drg No. 1-S.D. 893
3	Pallet Die No.		10855 (8.0) H	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	838 H, Step OD = 848 H	Tabber, 5°
6	Inside Diameter	Drg. No.	700.12 H	Step length = 38.5
7	Width of Pellet Die	Drg. No.	240 H	Under cut, 0.4 H
8	Grooves as per Drawing	Drg. No.	29 x 10 x 8 H / 28.5 x 10.5 x 8 H (6 x 8) H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Groove 1 H Back Both Side
11	Tapping Operator		N/C Shop	
12	Tapping PCD		785 H	Tapping No of Holes = 2
13	Tapping Hole Diameter		H16	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 32.4 H	Tapping Depth = 30.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 11/8/23

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				Counters 30°
2	External Relief Dia	8.5 H / 9.0 H	8.5 H All Lines	9.0 H All Lines		Ravi 11/8/23
3	External Relief Depth		28 H	19 H		
4	Inspection Done Before Hardening By (Name)					Ravi
5	Material Sent For Hardening By (Name)					Lark Ravnace
6	Material Sent For Hardening On Date		1	8	23	

### Inspected By (Sign) & Date

Ravi 11/8/23

*[Signature]*  
11/8/23

Reviewed by (Engineer-CNC)

Manager-QA