



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sarsuli 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.		18144	47/55
2	Machined By		V.T.L. n/c Shop	Drg No. 130/105
3	Pallet Die No.		13849(5.0) n/c	Revs n/c
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760mm 3rd ep 00.794mm	Tapper 12°
6	Inside Diameter	Drg. No.	650.12 mm	Step length 33 mm
7	Width of Pellet Die	Drg. No.	245 mm	Under cut 17 mm
8	Grooves as per Drawing	Drg. No.	27x8x12 mm   27x8x12 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		720 mm	
13	Tapping Hole Diameter		M24 - Check by M24 Bolt	Tapping n/c of holes 8 Back Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 30.3 mm Tapping Depth 28.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Savi 7/8/24

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							
2	External Relief Dia	5.5 mm	outside (2-3)	inner					
3	External Relief Depth		13 mm	8 mm					
4	Inspection Done Before Hardening By (Name)		Savi						
5	Material Sent For Hardening By (Name)		Lark Forname						
6	Material Sent For Hardening On Date		7	8	24				

### Inspected By (Sign) & Date

Savi 7/8/24

Savi 7/8/24

Reviewed by (Engineer-CNC)

Manager-QA