



# 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.		9995 to 10008	120/120
2	Machined By		V.T.L. n/c Shop	Drg No. I.S.D. 559
3	Pallet Die No.		10462 (3.0) mm	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 mm Step OD, 743.4 mm	Tapper, 10°
6	Inside Diameter	Drg. No.	630.12 mm	Step length 22 mm
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15x8x5 mm   15x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes, 16 Both Side
12	Tapping PCD		685 mm	
13	Tapping Hole Diameter		M20x Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Lawi 31/8/23

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 - 1 Hole Closed (A)	

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

1	Counter Sinking Depth & Finish	OK							Lawi 46
2	External Relief Dia	—	—	—	—	—	—	—	Relief
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								Lawi
5	Material Sent For Hardening By (Name)								Keshav
6	Material Sent For Hardening On Date								8 23

Inspected By (Sign) & Date

Lawi 31/8/23

Reviewed by (Engineer-CNC)

Manager-QA