



# 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.		1000	
2	Machined By		V.T.L. M/C Shop	39/50
3	Pallet Die No.		10591 (3.5) MM	Drg No. 1.E.C.29980
4	Die Category	Drg. No.	Outside	Rev 200
5	Out Side Diameter	Drg. No.	620.1 MM	
6	Inside Diameter	Drg. No.	Step OD, Tapers, 12° Step length - 18	
7	Width of Pellet Die	Drg. No.	520.12 MM	
8	Grooves as per Drawing	Drg. No.	222 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 MM   13x8x5 MM	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	Tapping No of Holes: 12 Roto Side
13	Tapping Hole Diameter		565 MM	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt 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

Ravi: 10/8/23

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							
2	External Relief Dia	4.0 MM	Outside (3-3)		Inner				Perf 35
3	External Relief Depth		18 MM		11 MM				
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	8	23				
Inspected By (Sign) & Date									Ravi: 10/8/23

*[Signature]*  
10/8/23

Reviewed by (Engineer-CNC)

Manager-QA