



# 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.		12828 to 12930	35/50/68
2	Machined By		V.T.L. N/C Shop	Dy. No. L3.0.09
3	Pallet Die No.		13325 (6.0)mm	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7mm, Step 02, 698mm	Topper 28
6	Inside Diameter	Drg. No.	548.1mm	Step length 31mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut = 2.5mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8mm / 32 x 7 x 8mm	(4.02)mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	2mm Deep Both Side
11	Tapping Operator		N/C Shop	Tapping No. of holes 2
12	Tapping PCD		619mm	Both Side
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 34.8mm	Tapping Depth = 32mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 21/9/24

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						Counter = 30
2	External Relief Dia	6.5mm / 7.0mm	6.5mm All Rows	7.0mm All Rows				Row = 12
3	External Relief Depth		31mm	16mm				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Formore					
6	Material Sent For Hardening On Date		21	9	24			

### Inspected By (Sign) & Date

Ravi 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA