



# 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

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12912 ✓	30/66
2	Machined By		V.T.L M/c Shop	Dry No. I.S.D. 320
3	Pallet Die No.		12950 (6.0) mm	Rev. 05 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm <sup>Grout 483</sup> Step OD - 693 mm	Tapper. 8'
6	Inside Diameter	Drg. No.	548.0 mm / 518.1 mm	Step Length - 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Order Cut - 2.5 mm
8	Grooves as per Drawing	Drg. No.	32x7x8 mm / 32x7x8 mm	(4x8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side
10	Drilling Area Surface Smoothness		OK	Step 2mm Deep
11	Tapping Operator		M/c Shop	Both side
12	Tapping PCD		619 mm	Tapping No
13	Tapping Hole Diameter		M16 check by M16 Bolt	of Holes - 4
14	Tapping On Second Side	Half pitch of 1st side		Both side
15	Tapping Hole Depth		Drill Depth - 34.8 mm	Tapping Depth 32
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 24/9/24

1	As per programme no.			Final Fitting Size Dry No. (I.S.D) 609 Rev. 02
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	7.0 mm		All Pores		Rows - 12
3	External Relief Depth			36 mm		
4	Inspection Done Before Hardening By (Name)			Ravi		
5	Material Sent For Hardening By (Name)			Lark Furnes		
6	Material Sent For Hardening On Date		24	9	24	

### Inspected By (Sign) & Date

Ravi . 24/9/24

Reviewed by (Engineer-CNC)

Manager-QA