



# 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.		12905	45/65
2	Machined By		V.T.L M/c Shop	Dry No: L.S.D-1157
3	Pallet Die No.		12978 (8.0)mm	(Rev 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 mm	Step OD 798mm
6	Inside Diameter	Drg. No.	660.12 mm	Teppier - 4°
7	Width of Pellet Die	Drg. No.	324	Step length 25.5mm
8	Grooves as per Drawing	Drg. No.	21.5x8x10 / 21.5x8x10	Under cut 4mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No. of Holes: 12
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M. 20 check by M.20 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Dept 30mm	Tapping Depth 28.5mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

1	As per programme no.		Ravi	24/09/24	2. Slot 32 wide
2	Gun Drilling Work Completed On				x 8 Deep (Both Side)
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					Counted. 60'
2	External Relief Dia	85mm	outside				Row. 27
3	External Relief Depth		(33)		Inner		
4	Inspection Done Before Hardening By (Name)		28mm		20mm		
5	Material Sent For Hardening By (Name)				Ravi		
6	Material Sent For Hardening On Date				Lark Furnel		

### Inspected By (Sign) & Date

								Ravi 24/09/24
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Reviewed by (Engineer-CNC)

Manager-QA