



# 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.		12905	45/65
2	Machined By		V.T.L. n/c Shop	Dy No. 1.3.0. 1151
3	Pallet Die No.		12985 (8.0)	Row 2
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790mm Step 002 798mm	Tapper 4
6	Inside Diameter	Drg. No.	660.12mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324mm	Under cut 24mm
8	Grooves as per Drawing	Drg. No.	21.5x8x10mm   21.5x8x10mm	
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 12 Both Side
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 30.4mm Tapping Depth 28.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 11/01/24	2 Slot 32.1mm width 8mm Deep Both Side
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 Counter 60°				
1	Counter Sinking Depth & Finish	OK		Row 2 27
2	External Relief Dia	8.5mm	Outside (3-3)	
3	External Relief Depth		28mm	Inner 20mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porvare	
6	Material Sent For Hardening On Date		1 10 24	
Inspected By (Sign) & Date			Ravi 11/01/24	

Reviewed by (Engineer-CNC)

Manager-QA