



# 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

As per work order

S.No.	Check Parameter	Specification	Observations	Remarks	
1	Work Order No.		12636	As per Drg. 61/71	
2	Machined By		V.T.L. M/C Shop	By No. 1802 861	
3	Pallet Die No.		13486(3.5)M	Rev. 05	
4	Die Category	Drg. No.	S. Jumbo		
5	Out Side Diameter	Drg. No.	1048 MM Step OD, 1033 MM	Tapper 3"	
6	Inside Diameter	Drg. No.	900.12 MM / 900.2 MM	Step length 37MM / 37.3	
7	Width of Pellet Die	Drg. No.	375 MM		
8	Grooves as per Drawing	Drg. No.	29.5 x 7.9 x 13 MM / 29.5 x 7.9 x 13 MM		
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 = 15 Both Side	
12	Tapping PCD		970 MM		
13	Tapping Hole Diameter		M24 - Check by M24 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth = 38.8 MM	Tapping Depth = 36.5	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ravi 8/10/24	2 Slot	
1	As per programme no.		_____	32.1 MM width 7.5 MM Deep Both Side	
2	Gun Drilling Work Completed On		_____		
3	Hole Finish In Gun Drilling	Marked	OK		
4	Defective Holes (If Any)		No - 2 Hole Colored		
Note : Mark the defective holes/Missed holes with the help of Permanent Marker					
1	Counter Sinking Depth & Finish	OK		Counter 60° Row 59	
2	External Relief Dia	4.0 MM	Outside (4.4)	Inner	
3	External Relief Depth		17 MM	10 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		8	10	24
Inspected By (Sign) & Date			Ravi 8/10/24		

Reviewed by (Engineer-CNC)

Manager-QA