



# 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.		13245	40/50	
2	Machined By		V.T.L. n/c Shop	Dy. No. 1209780	
3	Pallet Die No.		13110 (4.0) n/c	Rev. 00	
4	Die Category	Drg. No.	Extra wide		
5	Out Side Diameter	Drg. No.	619.8mm @ Step 00. Tappers 12° Step length 18.5		
6	Inside Diameter	Drg. No.	590.14mm		
7	Width of Pellet Die	Drg. No.	222 mm		
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5 mm		
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 212 Back Side	
12	Tapping PCD		565mm		
13	Tapping Hole Diameter		M20 - Check by M20 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth: 20.4mm	Tapping Depth: 18.5	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Soni 5/11/24		
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		
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	ok		Counter 60° Rev = 31	
2	External Relief Dia	4.3mm	Outside (3-3)	Inner	
3	External Relief Depth		14mm	10mm	
4	Inspection Done Before Hardening By (Name)		Soni		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		5	11	24
Inspected By (Sign) & Date			Soni 5/11/24		

Reviewed by (Engineer-CNC)

Manager-QA