



# 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.		13145-13284	35/40
2	Machined By		V.T.L. n/c Shop	Drg No-21 S.D-2782
3	Pallet Die No.		13039 (3.5) mm	Rev 200
4	Die Category	Drg. No.	3820	
5	Out Side Diameter	Drg. No.	500 mm	Step OD = 491 mm
6	Inside Diameter	Drg. No.	420.12 mm	Step length 16.8
7	Width of Pellet Die	Drg. No.	188 mm	
8	Grooves as per Drawing	Drg. No.	10x10x5 mm / 10x10x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		0.91" = Check by 0.91" Ball	Tabbing No. of holes = 8
14	Tapping On Second Side	Half pitch of 1st side	ok	Back side
15	Tapping Hole Depth		Drill Depth = 19.2 mm	Tabbing Depth = 17.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/1/24

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	4.0 mm	Outside (2-2)	Inner				Rev 27
3	External Relief Depth		8 mm	5 mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Purrace
6	Material Sent For Hardening On Date		11	11	24			

### Inspected By (Sign) & Date

Ravi 11/1/24

Reviewed by (Engineer-CNC)

Manager-QA