



# 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.		10135	33/50	
2	Machined By		V.T.L. n/c Shop	Drg No. L.R.D. 103	
3	Pallet Die No.		8819 (3.0)	Rev 2.01	
4	Die Category	Drg. No.	M78W		
5	Out Side Diameter	Drg. No.	700mm Step OD. 692mm Step length	19.5	
6	Inside Diameter	Drg. No.	600.12mm		
7	Width of Pellet Die	Drg. No.	265mm		
8	Grooves as per Drawing	Drg. No.	15x8x7mm / 15x8x7mm		
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: 16 Both Side	
12	Tapping PCD		640mm		
13	Tapping Hole Diameter		M20 - Check by M20 Ball		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth. 20.4mm Tapping Depth. 18.8		
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 21/8/23	2 slot 39.1mm 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					
1	Counter Sinking Depth & Finish	ok		Row = 47	
2	External Relief Dia	3.5mm	outside (2-3)	Inner	
3	External Relief Depth		23mm	17mm	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Ferrace		
6	Material Sent For Hardening On Date		21	8	23
Inspected By (Sign) & Date			Ravi 21/8/23		

Reviewed by (Engineer-CNC)

Manager-QA