



# 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.		13238 ✓	6/65.5 ✓
2	Machined By		V.T.L. n/c Shop	Dy No. 12.0.9.2
3	Pallet Die No.		13783 (12.0) n/c ✓	Pass ✓
4	Die Category	Drg. No.	58810	
5	Out Side Diameter	Drg. No.	639.7 mm, Step 02 = 641.7 mm / 652.3 mm	
6	Inside Diameter	Drg. No.	508.8 mm / Step 10 = 520.1 mm / 539.5 mm	Tapper 8°
7	Width of Pellet Die	Drg. No.	175 mm ✓	Step length 32 mm
8	Grooves as per Drawing	Drg. No.	30.721 x 7.85 mm / 9 x 25	Under cut 1 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side
10	Drilling Area Surface Smoothness		ok	Step 0.5 mm Deep
11	Tapping Operator		n/c Shop	
12	Tapping PCD		574 mm ✓	Tapping No.
13	Tapping Hole Diameter		M16 2 Check by M16 Bolt	of Hole = 4
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and The	Side = 4 all
15	Tapping Hole Depth		Drill Depth = 30.4 mm	Tapping Depth = 28.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 25/11/24	4912
1	As per programme no.		_____	51.5 long
2	Gun Drilling Work Completed On		_____	28.1 mm depth
3	Hole Finish In Gun Drilling	Marked	ok	15 mm Deep
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 = 6 Dep = 5
2	External Relief Dia		12.5 mm	All Rows
3	External Relief Depth		5.5 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		25 11 24	
Inspected By (Sign) & Date			Ravi 25/11/24	

Reviewed by (Engineer-CNC)

Manager-QA