



# 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.		13348	57/57 ✓
2	Machined By		V. T. L. N/C Shop	Drill. 1339/1302 ✓
3	Pallet Die No.		13356(3.0) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	644 mm, Step 00 = 682 mm	596 mm ✓
6	Inside Diameter	Drg. No.	530.12 mm ✓	Step length = 27 mm ✓
7	Width of Pellet Die	Drg. No.	278 mm ✓	Under cut = 19 mm ± 1.5 mm ✓
8	Grooves as per Drawing	Drg. No.	2748 ± 8 mm   4348 ± 8 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 = 8 ]
12	Tapping PCD		594 mm ✓	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third Side One Slot	
15	Tapping Hole Depth		Drill Depth = 25.4 mm - Tapping Depth = 28.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 26/11/24

1	As per programme no.		_____	[ 1 Slot 29.1 mm width 18 mm Deep ]
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

Counter = 60

1	Counter Sinking Depth & Finish	ok							Low = 42
2	External Relief Dia	—	—	No Relief					
3	External Relief Depth	—	—	—					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date			26	11	24			

### Inspected By (Sign) & Date

Ravi 26/11/24

Reviewed by (Engineer-CNC)

Manager-QA