



# 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

8689

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13106	48/66
2	Machined By		V.T.L H/C Shop	55/66
3	Pallet Die No.		13345 (8.0) mm	Drg No. 1.8.0-1.95
4	Die Category	Drg. No.	M. Jumbo	Rev 2.00
5	Out Side Diameter	Drg. No.	680 mm - Step OD = 692.5 mm	Step length 2.0
6	Inside Diameter	Drg. No.	548.12 mm (Bor = 548.12 mm)	Tapper. 5°
7	Width of Pellet Die	Drg. No.	215 mm	Gdes cut = 3.12 mm
8	Grooves as per Drawing	Drg. No.	30.5 x 6 x 8 mm   30.5 x 6 x 8 mm	(G x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		N/C Shop	Inner Deep Both
12	Tapping PCD		620 mm	Side
13	Tapping Hole Diameter		N/C - Check by N/C Bolt	Tapping dia of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 32.4 mm	Tapping Depth 30.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 31/7/24

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						Counter 30
2	External Relief Dia	9.0 mm	ok	1st Rad All Rows	11 mm	11 mm	Row 12
3	External Relief Depth			18 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			3	12	24	

### Inspected By (Sign) & Date

Ravi 31/7/24

Secty 31/7/24

Reviewed by (Engineer-CNC)

Manager-QA