



# 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.		13455	39/51
2	Machined By		V. T.L. H/c Shop	By 18.0.537
3	Pallet Die No.		12911(3.0)H	Review
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	73.2mm / Step OD 74.3mm	Tapped 4"
6	Inside Diameter	Drg. No.	63.012mm / 63.02mm	Step length 27.5
7	Width of Pellet Die	Drg. No.	255mm	Under cut 5.5mm
8	Grooves as per Drawing	Drg. No.	22x8x7mm / 22x8x7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping of holes 12 Botu side
12	Tapping PCD		685mm	
13	Tapping Hole Diameter		M22 - Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 28.3mm	Tapping Depth 28.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/12/24

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 - 1 Hole Polished

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

Counter 60°

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.5mm	outside (3-3)		inner			
3	External Relief Depth		18mm		18mm			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		4	12	24			

### Inspected By (Sign) & Date

Ravi 4/12/24

Reviewed by (Engineer-CNC)

Manager-QA