



# 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.		13238 ✓	60/65.5 ✓
2	Machined By		V.T.L. N/A Shop	Dy. No. 62.9 ✓
3	Pallet Die No.		14078 (12.0) ✓	Rev: 03 ✓
4	Die Category	Drg. No.	53310	
5	Out Side Diameter	Drg. No.	639.7 mm, Step 0.0, 652.9 mm	Tapper = 8° ✓
6	Inside Diameter	Drg. No.	508.8 mm (10 Step = 539.7 / 523.3)	Step length = 32 mm ✓
7	Width of Pellet Die	Drg. No.	175 mm ✓	
8	Grooves as per Drawing	Drg. No.	30 x 21 x 7.25 mm / 9 x 25 mm	Face Side ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Step 0.5 mm ✓
10	Drilling Area Surface Smoothness		ok	Depth ✓
11	Tapping Operator		N/A Shop	Tapping No. ✓
12	Tapping PCD		574 mm ✓	of holes = 4 ✓
13	Tapping Hole Diameter		M16 - Check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 1st side 4 Slot ✓	
15	Tapping Hole Depth		Drill Depth: 30.3 mm Tapping Depth: 28.6 mm ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 14/12/24

1	As per programme no.			4 Slot
2	Gun Drilling Work Completed On			51.5 mm long
3	Hole Finish In Gun Drilling	Marked	ok	28 mm wide
4	Defective Holes (If Any)		No	15 mm Depth

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

Counter = 60°

1	Counter Sinking Depth & Finish	ok						Row = 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		14	12	24			

### Inspected By (Sign) & Date

Ravi 14/12/24

Satyam  
14/12/24  
Reviewed by (Engineer-CNC)

Manager-QA