



# 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

6995

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10105	31/50/65
2	Machined By		V.T.L. M/c Shop	Drg No. 1.3.02.693
3	Pallet Die No.		9477 (3.8) M-1	Rev. 2.00
4	Die Category	Drg. No.	Jumbo	✓
5	Out Side Diameter	Drg. No.	830 M-1, Step OD, 823 M-1	Tapper = 4°
6	Inside Diameter	Drg. No.	700.12 M-1	Step length = 38.5
7	Width of Pellet Die	Drg. No.	324 M-1	✓
8	Grooves as per Drawing	Drg. No.	30x8x8.5 M-1   30x8x8.5 M-1	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No. of holes: 12 Retro Side
12	Tapping PCD		76 M-1	
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: 36.4 M-1	Tapping Depth: 34.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Res: 24/8/23

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	OK					Row 46
2	External Relief Dia	4.3 M-1 / 4.8 M-1	4.3 M-1 All Lines	4.8 M-1 All Lines			
3	External Relief Depth		34 M-1	15 M-1			
4	Inspection Done Before Hardening By (Name)		Res				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		24	8	23		

### Inspected By (Sign) & Date

Res: 24/8/23

Reviewed by (Engineer-CNC)

Manager-QA