



# 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

8840

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13688	33/70
2	Machined By		V.T.L. H/c Shop	Drg No. 180.37
3	Pallet Die No.		13342(8.0)mm	Rev. 03
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	688 mm	Step 00, 697.8 mm, Tapper. 5°
6	Inside Diameter	Drg. No.	546.12 mm (Bot = 548.12 mm)	Step length. 28.5
7	Width of Pellet Die	Drg. No.	215 mm	Order cot. 1.8 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 mm / 29.5 x 10 x 8 mm	(6 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step 1.4 mm Deep Both
11	Tapping Operator		H/c Shop	Side
12	Tapping PCD		618 mm	Tapping No. of holes = 2
13	Tapping Hole Diameter		M16, Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 30.3 mm	Tapping Depth. 30.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 25/12/24

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

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

1	Counter Sinking Depth & Finish	ok						Counter 30°
2	External Relief Dia	9.0 mm	All Rows					Row 12
3	External Relief Depth		37 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		25	12	24			

### Inspected By (Sign) & Date

Ravi 25/12/24

*[Signature]*  
25/12/24

Reviewed by (Engineer-CNC)

Manager-QA