



# 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.		9664	30 / 55 / 75
2	Machined By		V.T.L. n/c Shop	Drilling 1.5.12 894
3	Pallet Die No.		10441 (G.O) n/c	Reo: 00
4	Die Category	Dr. No.	NJEN	✓
5	Out Side Diameter	Dr. No.	722 n/c Step 00, 777 n/c	776 n/c / 675 n/c
6	Inside Diameter	Dr. No.	578.14 n/c	Step length: 42 n/c 84.5
7	Width of Pellet Die	Dr. No.	270 n/c	Under cut: 27.5 n/c
8	Grooves as per Drawing	Dr. No.	98 x 8 x 12 n/c / 106 x 8 x 12 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of holes 6 ✓
12	Tapping PCD		660 n/c	
13	Tapping Hole Diameter		φ31.4" - Check by φ31.4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 2nd Side One Slot	
15	Tapping Hole Depth		Drill Depth: 350 n/c Tapping Depth: 33.4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Res: 13/6/23	1 SLOT 39.1 n/c width 28 n/c Deep
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	
<b>Note :</b> Mark the defective holes/Missed holes with the help of Permanent Marker				Counter Bo
1	Counter Sinking Depth & Finish	OK		
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Lines / 7.0 n/c All Lines	
3	External Relief Depth		4.5 n/c / 20 n/c	
4	Inspection Done Before Hardening By (Name)		Res:	
5	Material Sent For Hardening By (Name)		Lark Forge	
6	Material Sent For Hardening On Date		13 / 6 / 23	
Inspected By (Sign) & Date			Res: 13/6/23	

Reviewed by (Engineer-CNC)

Manager-QA