



# 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.		9794	
2	Machined By		M/C Shap - U7L	39/50
3	Pallet Die No.		10322 (30mm)	Dring H - hole sta
4	Die Category	Drg. No.	885W	
5	Out Side Diameter	Drg. No.	620 mm OD Step - 612 mm	Step height - 19.5
6	Inside Diameter	Drg. No.	520 mm	(8)
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	(Tapping Holes)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Holes - Both Side
10	Drilling Area Surface Smoothness		OK	(12)
11	Tapping Operator		M/C Shap	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 check M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 20.6 mm Tapping Depth - 18.9 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

J. Anjan 22/6/23

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				
2	External Relief Dia	Φ 3.5	outside	11 mm	11 mm	ALL
3	External Relief Depth		17 mm (B-3)			
4	Inspection Done Before Hardening By (Name)		Sanjew			
5	Material Sent For Hardening By (Name)		U7L - Manager			
6	Material Sent For Hardening On Date		22	6	23	

Inspected By (Sign) & Date

J. Anjan 22/6/23

Rev.

Reviewed by (Engineer-CNC)

Manager-QA