



# 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.		9947	60/60
2	Machined By		V.T.L. n/c Step	Drg No. L.S.O. 584
3	Pallet Die No.		11037 (10.0) n/c	Recess
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm / Step 0.0798 mm	Tapper 4°
6	Inside Diameter	Drg. No.	660.12 mm / 660.14 mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324mm	Undercut 9mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm / 21.5 x 8 x 10 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Step	
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20: Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 30.4mm / Tapping Depth: 28.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 21/10/23

1	As per programme no.		_____	2 SLOT 39.1mm wide 8mm Deep Both Side
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							Ravi 21/10/23
2	External Relief Dia	—	—	—	—	—	—	—	no - Relief
3	External Relief Depth	—	—	—	—	—	—	—	
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Keshav
6	Material Sent For Hardening On Date		21	10	23				

### Inspected By (Sign) & Date

Ravi 21/10/23

Reviewed by (Engineer-CNC)

Manager-QA