

1095 Reorder 10839-108.50, (1123)

6316



# 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.		10245	34/100
2	Machined By		V.T.C H/C Shop	Drg No. 1.2.09743
3	Pallet Die No.		8000 (8.0)mm	Rev: 03, 02
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1051 mm Step OD 1042 mm	Step length 32.5
6	Inside Diameter	Drg. No.	851.14   851.2 mm	
7	Width of Pellet Die	Drg. No.	851 mm	
8	Grooves as per Drawing	Drg. No.	50x11x10.5 mm   50x11x10.5	Tappers 15° Both Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 34 Both Side
12	Tapping PCD		958 mm	
13	Tapping Hole Diameter		M30 - Check by M30 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 44 mm Tapping Depth 41.4 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 26/10/23

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						Counter = 30°
2	External Relief Dia	9.0 mm	All Lines					
3	External Relief Depth		66 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		26	10	23			

Inspected By (Sign) & Date Ravi 26/10/23

Satyam 26/10/23

Reviewed by (Engineer-CNC)

Manager-QA