



# 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.		10368	27/4/13
2	Machined By		V.T.L n/c Shop	27/3/13
3	Pallet Die No.		10480 (6.5) mm	Dy. No. 1.30.377
4	Die Category	Drg. No.	M. Jumbo	Rev 203
5	Out Side Diameter	Drg. No.	688 mm	Step OD: 697.8 mm
6	Inside Diameter	Drg. No.	548.12 mm	Tapper 2 5°
7	Width of Pellet Die	Drg. No.	215 mm	Step length: 38.5 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 mm	1 side cut: 1.8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 10 x 8 mm	(6x8) mm
10	Drilling Area Surface Smoothness		ok	Face Side step mm
11	Tapping Operator		n/c Shop	Back Both Side
12	Tapping PCD		618 mm	
13	Tapping Hole Diameter		N/C - Check by HIG Bolt	Tapping No of Holes: 2 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 32.4 mm	Tapping Depth: 30.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/10/13

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

Counter 2 30°

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	7.0 mm / 7.5 mm	7.0 mm 1st Pad	7.0 mm 2nd Pad	7.5 mm 1st Pad	7.5 mm 2nd Pad		
3	External Relief Depth		4.3 mm	4.3 mm	7.5 mm	7.5 mm		
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		26	10	23			

Inspected By (Sign) & Date

Ravi 26/10/13

Reviewed by (Engineer-CNC)

Manager-QA