



# 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.			
2	Machined By		10541	25/35/66
3	Pallet Die No.		N.T.L. n/c Shop	Drg No. 1-S.D. 609
4	Die Category	Drg. No.	10895 (G.O) MM	Revised
5	Out Side Diameter	Drg. No.	N. Jumbo	
6	Inside Diameter	Drg. No.	680.69 MM, Step OD, G93 MM	Tapper 8
7	Width of Pellet Die	Drg. No.	548.12 MM	Step length 31 MM
8	Grooves as per Drawing	Drg. No.	195 MM	Under cut 2.5 MM
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 MM / 32 x 7 x 8 MM (4x2) MM	
10	Drilling Area Surface Smoothness		OK	Face side 3rd side Back side
11	Tapping Operator		N/c Shop	
12	Tapping PCD		619 MM	
13	Tapping Hole Diameter		NIG 2 Check by NIG Bolt	Tapping no of holes 4
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		Drill Depth = 33.4 MM	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/1/23

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°	Ravi 12
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM	All Lines	7.0 MM	All Lines
3	External Relief Depth			4 MM		3 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		3	11	23	

Inspected By (Sign) & Date

Ravi 31/1/23

Reviewed by (Engineer-CNC)

Manager-QA