



# 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.		10654 ✓	56/60 ✓
2	Machined By		V.T.L. H/C Shop	Drg. No. 1.8.2. 920
3	Pallet Die No.		F991 (H.C.) ✓	Rev. No. ✓
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	670mm / Step 602 673mm	Tap hole = 12mm
6	Inside Diameter	Drg. No.	550mm ✓	Step length = 30mm
7	Width of Pellet Die	Drg. No.	935mm ✓	Width cut = 1.5mm ✓
8	Grooves as per Drawing	Drg. No.	24.5 x 8 x 9mm / 24.5 x 8 x 9mm	
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 = 8 Both Side
12	Tapping PCD		620mm ✓	
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 = 29mm / Tapping Depth = 27mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/11/23

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								Ravi 29
2	External Relief Dia	4.5mm	outside (3-3)		inner					
3	External Relief Depth	/	12mm		4mm					
4	Inspection Done Before Hardening By (Name)								Ravi	
5	Material Sent For Hardening By (Name)								Lark Furnace	
6	Material Sent For Hardening On Date			18	11	23				
Inspected By (Sign) & Date		Ravi 18/11/23								

Reviewed by (Engineer-CNC)

Manager-QA