



# 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)

6462

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10332	
2	Machined By		V72 MIC STD	35/50
3	Pallet Die No.		1144 (4.5) mm	Drg No. 223 Res CO
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	727 mm S+DOD-754.3	Tapped 10"
6	Inside Diameter	Drg. No.	630, 827 mm	Step height = 2.9
7	Width of Pellet Die	Drg. No.	256 mm	
8	Grooves as per Drawing	Drg. No.	19.5 x 10 x 8 mm	Undercut = 13-6 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No of
11	Tapping Operator		MIC Std -	Holes 12
12	Tapping PCD		689 mm	Both side
13	Tapping Hole Diameter		M24 (check M24 Bolt)	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth = 28.4 mm	Tapping Depth 26.5 mm
16	Perpendicularity of Tapped Hole		7/8	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

*[Signature]* 20/11/23

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		N/O	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	Ø 5.0	outside	INNER			
3	External Relief Depth		20 mm (8-9)	15 mm AU			
4	Inspection Done Before Hardening By (Name)		Sanjeev				
5	Material Sent For Hardening By (Name)		work for me				
6	Material Sent For Hardening On Date		20	11	23		

### Inspected By (Sign) & Date

*[Signature]* 20/11/23

Reviewed by (Engineer-CNC)

Manager-QA