



# 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.		10673	30/45/80
2	Machined By		V.T.L. M/c Shop	Drg No. 150700
3	Pallet Die No.		11379 (6.0) ✓	Rev. 02 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730mm, Step 00, 732mm	632mm
6	Inside Diameter	Drg. No.	572.14mm	Step length 30mm 13.5mm
7	Width of Pellet Die	Drg. No.	219mm	Undercut 2mm ✓
8	Grooves as per Drawing	Drg. No.	75x8x8mm   58x8x8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		650mm	of holes = 6
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 1st Side One Slot	
15	Tapping Hole Depth		Drill Depth 40.5mm Tapping Depth 38.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 23/11/23

1	As per programme no.			1 SLOT 36mm width 19mm Deep
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						Row 8
2	External Relief Dia	6.5mm   7.0mm	6.5mm All Lines	7.0mm All Lines				
3	External Relief Depth		50mm	35mm				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		23	11	23			

**Inspected By (Sign) & Date**

Ravi 23/11/23

Soham 23/11/23

Reviewed by (Engineer-CNC)

Manager-QA