



# 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.		9835	53/60
2	Machined By		V.T.L. n/c Shop	Dy. No. 1.5.0.11
3	Pallet Die No.		10377 (3.8)mm	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm	Step 00 = 792mm
6	Inside Diameter	Drg. No.	660.12mm	Step length 26mm
7	Width of Pellet Die	Drg. No.	324mm	Under cut 8mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8mm	21.5 x 8 x 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		725mm	
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 31.4mm	Tapping Depth 29.7mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/7/23

1	As per programme no.			2 slot 32.1mm width 8mm Deep Both Side
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 48
2	External Relief Dia	4.3mm	outside (3-3)		Inner					
3	External Relief Depth		14mm		7mm					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date			4	7	23				

### Inspected By (Sign) & Date

Ravi 4/7/23

Reviewed by (Engineer-CNC)

Manager-QA