



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6634

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.		10897	
2	Machined By		V.T.L. w/c Shop	51/56
3	Pallet Die No.		11440 (3.8) mm	Dr. H. 1.3.0. 810
4	Die Category	Drg. No.	N. Jumbo	Revised
5	Out Side Diameter	Drg. No.	742 mm	
6	Inside Diameter	Drg. No.	630.12 mm / 631.4 mm	Step length 94.5 mm
7	Width of Pellet Die	Drg. No.	255 mm	
8	Grooves as per Drawing	Drg. No.	22 x 8 x 7 mm	OD As per
9	Fitting Sizes on CNC Plate	Drg. No.	22 x 8 x 7 mm	discussion with Sales
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		685 mm	Tapping No. of holes 12
13	Tapping Hole Diameter		H22 2 Check by H22 Bolt	R. in Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 29.5 mm	Tapping Depth 27 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 19/12/23

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								
2	External Relief Dia	4.3 mm	Outside (3-3)		Inner					
3	External Relief Depth		12 mm		5 mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date		19	12	23					

Inspected By (Sign) & Date Ravi 19/12/23

Reviewed by (Engineer-CNC) Satish 19/12/23

Manager-QA