



# 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.		9812	40/55
2	Machined By		V.T.L. H/C Shop	Dr. No. 12.0.557
3	Pallet Die No.		10498 (8.0) H/C	Rev 2.00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	629.9 mm <sup>Ⓢ</sup> Step 002 624 mm	Tapping 212°
6	Inside Diameter	Drg. No.	520.12 mm	Step length 20 mm
7	Width of Pellet Die	Drg. No.	181.9 mm <sup>Ⓢ</sup>	
8	Grooves as per Drawing	Drg. No.	12x10x5 mm / 12x10x4.9 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 mm	Tapping No of Holes. 12 Both Side
13	Tapping Hole Diameter		MIS Check by MIS Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.5 mm	Tapping Depth: 18.8 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 11/7/23

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

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

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	8.3 mm	Outside 23-35				Ravi
3	External Relief Depth		23 mm	Inner	15 mm		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						Ravi
6	Material Sent For Hardening On Date						Lark Furnace

### Inspected By (Sign) & Date

Ravi 11/7/23

Reviewed by (Engineer-CNC)