



# 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

6977

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11244	40/55
2	Machined By		V.T.L. w/c Shop	Dy. No. 1-25/4924
3	Pallet Die No.		11350 (80) mm	Rev. No.
4	Die Category	Drg. No.	Subsidiary	
5	Out Side Diameter	Drg. No.	630 mm, Step 00.612 mm, Step length 19.4	
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm   13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/c Shop	Tapping H of Hole 12 Both Side
12	Tapping PCD		565 mm	
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 21.3 mm Tapping Depth 18.8 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/7/24

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						Counter Sink 18
2	External Relief Dia	8.5 mm	outside (3-3)		Inner			
3	External Relief Depth		23 mm		15 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		20	2	24			

Inspected By (Sign) & Date

Ravi 20/7/24

Reviewed by (Engineer-CNC)

Manager-QA