



# 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)

5618

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9631	25/40
2	Machined By		N.T.L. N/C Shop	Drg No. = L.E.C. 15062
3	Pallet Die No.		10000 (2.8) mm	Rev 2 mm
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm	Step OD = 498.88
6	Inside Diameter	Drg. No.	480.12 mm	Tapper = 12°
7	Width of Pellet Die	Drg. No.	158 mm	Step length = 18 mm
8	Grooves as per Drawing	Drg. No.	18.3 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12.2 x 8 x 3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	
13	Tapping Hole Diameter		454 mm	Tapping No of holes = 8
14	Tapping On Second Side	Half pitch of 1st side	N20 Check by N20 Bolt	Both side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 19.8 mm	Tapping Depth = 17.2 mm
17	Visual Inspection Before Gun Drilling		yes	

### Inspected By (Sign) & Date

Res: 7/6/23

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	3.3 mm	outside (2-2)	inner					POF = 28
3	External Relief Depth		18 mm	15 mm					
4	Inspection Done Before Hardening By (Name)								Res:
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date								7 8 23

### Inspected By (Sign) & Date

Res: 7/6/23

9/6/23

Reviewed by (Engineer-CNC)

Manager-QA