



# 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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9788	55/60
2	Machined By		V.T.L. n/c Shop	Drg No 1.3.D.2 584
3	Pallet Die No.		10505 (10.0) mm	Revol
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 mm Step OD, 797.7 mm 798 mm	
6	Inside Diameter	Drg. No.	660.12 mm	Step length, 25.75
7	Width of Pellet Die	Drg. No.	323.7 mm	25.2
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm   21.3 x 8 x 10 mm	Under cut 2.9 mm   8.7 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. 9
12	Tapping PCD		785 mm	Holes 12
13	Tapping Hole Diameter		M20	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4 mm	Tapping Depth = 28.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 21/7/23

1	As per programme no.				2 slot
2	Gun Drilling Work Completed On				32.1 mm width
3	Hole Finish In Gun Drilling	Marked	ok		8 mm Deep
4	Defective Holes (If Any)		No		Both Side

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

1	Counter Sinking Depth & Finish	ok									Ravi 19
2	External Relief Dia	10.5 mm	Outside (3-3)		Inner						
3	External Relief Depth		10 mm		5 mm						
4	Inspection Done Before Hardening By (Name)										Ravi
5	Material Sent For Hardening By (Name)										Lark Purware
6	Material Sent For Hardening On Date			21	7	23					

### Inspected By (Sign) & Date

Ravi 21/7/23

Reviewed by (Engineer-CNC)

Manager-QA