



# 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.		11870	40/60	
2	Machined By		V. T. L. n/c Shop	Dry Hole L.S.D. 584	
3	Pallet Die No.		12304 (G.O) ✓	Revol	
4	Die Category	Drg. No.	Jumbo		
5	Out Side Diameter	Drg. No.	780 mm Step 002 788 mm	Tapping ✓	
6	Inside Diameter	Drg. No.	660.12 mm	Step length 25.5	
7	Width of Pellet Die	Drg. No.	324 mm	Undercut 9mm	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm / 21.5 x 8 x 10 mm		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		n/c Shop	Tapping Holes of hole 12 Both Side	
12	Tapping PCD		725 mm		
13	Tapping Hole Diameter		M20 Check by H20 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth = 31 mm	Tapping Depth = 29.8 mm	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 13/5/24	2 slot 32.1 mm width 8 mm Deep	
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 = 60 Ravi = 34	
2	External Relief Dia	6.5 mm	outside (2.3)	Inner	
3	External Relief Depth		26 mm	20 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		13	5	24
Inspected By (Sign) & Date			Ravi 13/5/24		

Satish 13/5/24

Reviewed by (Engineer-CNC)

Manager-QA