



# 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.		8913 to 10026	41/55
2	Machined By		V.T.L. n/c Shop	Dyn No. 1.2.C2 7430
3	Pallet Die No.		10042 (3.5) mm	Rev 2.00 7431
4	Die Category	Drg. No.	Jumbo	7432
5	Out Side Diameter	Drg. No.	770 mm Step 00. 793 mm	Step length 27
6	Inside Diameter	Drg. No.	860.12 mm	Undercut = 11.5 mm
7	Width of Pellet Die	Drg. No.	323.9 mm	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 12 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 12 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 mm	Tapping No of holes 12 Both Side
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 31.4 mm Tapping Depth 29.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 1/8/23	
1	As per programme no.			2 Slot 32.1 mm width 8 mm Deep Both Side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish		ok	
2	External Relief Dia		4.0 mm	Both side (3-3) Rave 52
3	External Relief Depth		21 mm	Inner 14 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For name	
6	Material Sent For Hardening On Date		1 8 23	
Inspected By (Sign) & Date			Ravi 1/8/23	

Reviewed by (Engineer-CNC)

Manager-QA