



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.		12107	55/60
2	Machined By		V.T.L n/c Shop	Drg No. 1.3.D.995
3	Pallet Die No.		13471 (H10) n/c	Rev: III
4	Die Category	Drg. No.	Ex-Inside	
5	Out Side Diameter	Drg. No.	240mm / 3rd 0.02 621.5mm	Tapper 12°
6	Inside Diameter	Drg. No.	520.14mm	Step length 91.5
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Bottom Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/6/24

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 60°
2	External Relief Dia	4.5mm	Outside (3-3)	Inner			Rev 31
3	External Relief Depth		13mm	5mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		26	6	24		

Inspected By (Sign) & Date

Ravi 26/6/24

Satyam 26/6/24

Reviewed by (Engineer-CNC)

Manager-QA