



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11739	40/65
2	Machined By		V.T.L. n/c. Shop	Dy. n/c. 12.02.1048
3	Pallet Die No.		12501 (4.0) 44	Rev. 00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1030 mm Step 00, 1041.5 mm	Tapped 4°
6	Inside Diameter	Drg. No.	900.3 mm	Step length 40 mm
7	Width of Pellet Die	Drg. No.	337 mm	Under cut = 5.75
8	Grooves as per Drawing	Drg. No.		
9	Fitting Sizes on CNC Plate	Drg. No.	31x9x7 mm / 31x9x7 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		970 mm	
13	Tapping Hole Diameter		M24	Check by M24 Bolt
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth, 35.4 mm	Tapping Depth, 39.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/7/24

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 - 2 Hole Closed

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	5.0 mm	Outside (3-3)	Adjust Line (3-3)	Inner			Low = 45
3	External Relief Depth		33 mm	39 mm	25 mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		8	7	24			

Inspected By (Sign) & Date

Ravi 8/7/24

Reviewed by (Engineer-CNC)

Manager-QA