



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.		12243	28/38/66
2	Machined By		V.T.L. N/A Shop	Drg No. 68.02.609
3	Pallet Die No.		12797 (8.0) mm	Rev. 01
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	680.7 mm, Step OD: 693 mm	Top brass 8"
6	Inside Diameter	Dr. No.	548.12 mm	Step length: 31 mm
7	Width of Pellet Die	Dr. No.	195 mm	Undercut: 2.5 mm
8	Grooves as per Drawing	Dr. No.	32 x 7 x 8 mm 32 x 7 x 8 mm	(4 x 3) mm
9	Fitting Sizes on CNC Plate	Dr. No.	OK	[Face side Step 2 mm Deep Both side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		619 mm	[Tapping No of Holes: 4 Both Side]
13	Tapping Hole Diameter		N/A Check by N/A Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 33.8 mm	Tapping Depth: 36.5 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/7/24

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

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

Counter: 30

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Rows	7.0 mm All Rows					
3	External Relief Depth		38 mm	28 mm					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Forncel						
6	Material Sent For Hardening On Date		19	7	24				

Inspected By (Sign) & Date

Ravi 19/7/24

Sut...
20/7/24

Reviewed by (Engineer-CNC)

Manager-QA