



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7918

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.			
2	Machined By		12415	30/28/25
3	Pallet Die No.		V.T.L. n/c Shop	Dy. No. 158-986
4	Die Category	Dr. No.	12436(4.0) n/c	Row 20
5	Out Side Diameter	Dr. No.	Jumbo	
6	Inside Diameter	Dr. No.	79 n/c, 2nd OD. 792 n/c	Step length 28.5
7	Width of Pellet Die	Dr. No.	660.12 n/c	Undercuts 1 n/c
8	Grooves as per Drawing	Dr. No.	324 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	21.5 x 8 x 8 n/c / 21.5 x 8 x 8 n/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		n/c Shop	Tapping of holes of 2nd side
13	Tapping Hole Diameter		79.5 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20. Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 31.3 n/c	Tapping Depth 29.5
17	Visual Inspection Before Gun Drilling		yes OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi 30/7/24
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		OK No - 2 Hole Colored

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

1	Counter Sinking Depth & Finish	OK			Counter 30
2	External Relief Dia	4.8 n/c / 5.0 n/c	4.8 n/c All Rows	5.0 n/c All Rows	Row 247
3	External Relief Depth		35 n/c	27 n/c	
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		30	7 24	

Inspected By (Sign) & Date

[Signature]
30/7/24

Ravi 30/7/24

Reviewed by (Engineer-CNC)

Manager-QA