



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.		12549	66/66
2	Machined By		V.T.L. n/c Shop	Dy. No. 12302809
3	Pallet Die No.		12800 (8.0) mm	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step 65 = 693 mm	Tap hole 8"
6	Inside Diameter	Drg. No.	548.12 mm	Step length 3 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm / 32 x 7 x 8 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 mm Deep Both Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 mm	Tapping No. of holes = 4
13	Tapping Hole Diameter		H16 = Check by H16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 34.4 mm	Tapping Depth 31.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/8/24

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 = 30
2	External Relief Dia						Rev. 10
3	External Relief Depth			No Relief			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Romane			
6	Material Sent For Hardening On Date			23	8	24	

Inspected By (Sign) & Date

Ravi 23/8/24

Reviewed by (Engineer-CNC)

Manager-QA