



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.		12814	55/60
2	Machined By		N.T.L. n/c Shop	Dy No. 12.92-13
3	Pallet Die No.		12852 (5.0) n/c	Row 20
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720mm Step 00-693mm	Tabber 12
6	Inside Diameter	Drg. No.	600.12mm	Step length 20mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	14x8x7mm / 14x8x7mm	
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 Back Side
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.4mm	Tapping Depth 20.6
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 60° Row = 26
2	External Relief Dia	5.5mm	Outside (3-3)		Inner			
3	External Relief Depth		15mm		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		23	8	24			

Inspected By (Sign) & Date

Ravi 23/8/24

Reviewed by (Engineer-CNC)

Manager-QA