



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.		12624	410/50-355
2	Machined By		V.T.L. H/c Shop	Dy. M. Lark 2370
3	Pallet Die No.		12892 (2.2)mm	
4	Die Category	Dr. No.	Ends wide	
5	Out Side Diameter	Dr. No.	620mm Step OD. 612mm	Step length 17.5
6	Inside Diameter	Dr. No.	520.12mm	
7	Width of Pellet Die	Dr. No.	222mm	
8	Grooves as per Drawing	Dr. No.	13x8x5 mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H. of holes. 12 Back side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		H20, Check by H20 Bol.	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.4mm	Tapping Depth. 18.5
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

Counter. 600 Rep 237

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	2.8mm	80 Side (3-3)	Inner			
3	External Relief Depth		16mm	10mm			
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	24			

Inspected By (Sign) & Date

Ravi 23/8/24

23/8/24

Reviewed by (Engineer-CNC)

Manager-QA