



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.		12858	39/47
2	Machined By		V.T.L H/c Shop	Drg No. 12.0.875
3	Pallet Die No.		12838 (3.0) mm	Rev 00
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	614 mm	Step 002 622.5 mm
6	Inside Diameter	Drg. No.	520.12 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	222 mm	Undercut 4.2 mm
8	Grooves as per Drawing	Drg. No.	1378x5 mm / 1378x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 mm	Tapping No of holes 12 Both Side
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 20.4 mm	Tapping Depth 187
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 28/8/24

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 80°
2	External Relief Dia	3.5 mm	Outside (3-3)	Inner			Low 38
3	External Relief Depth		14 mm	8 mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		28	8	24		

Inspected By (Sign) & Date Ravi 28/8/24

Reviewed by (Engineer-CNC) [Signature] 27/8/24

Manager-QA