



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.		12879 ✓	45/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.C.2 10969
3	Pallet Die No.		13370 (4.0) ✓	Rev 201
4	Die Category	Drg. No.	Tumbo	
5	Out Side Diameter	Drg. No.	760mm ✓ Step OD: 799mm	Step length: 27
6	Inside Diameter	Drg. No.	660.12 mm ✓	Undercut: 16mm ✓
7	Width of Pellet Die	Drg. No.	324 mm ✓	
8	Grooves as per Drawing	Drg. No.	21x8x10mm / 21x8x10mm ✓	
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 = 2 Both Side
12	Tapping PCD		725mm ✓	
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: 27.4mm	Tapping Depth: 25.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/9/24

1	As per programme no.		_____	2 slots ✓ 38.1mm width 9mm Rasp Both Side
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: 600 Rasp: 48
2	External Relief Dia	4.5mm ✓	Outside (3-3)		Inner		
3	External Relief Depth		13mm ✓		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		20	9	24		

Inspected By (Sign) & Date

Ravi 20/9/24

Reviewed by (Engineer-CNC)

Manager-QA