



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.		12905	40/60
2	Machined By		V. T. L. n/c Shop	Qty 10, 1-3.0, 584
3	Pallet Die No.		12898 (4.0) mm	Rev. 01
4	Die Category	Drg. No.	Tumbo	
5	Out Side Diameter	Drg. No.	780 mm, Step 00, 798 mm	Tabber 24
6	Inside Diameter	Drg. No.	660.12 mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 mm	Under cut 9 mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm 21.5 x 8 x 10 mm	
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 212 Both side
12	Tapping PCD		725 mm	
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 30.4 mm	Tapping Depth 36
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/9/24

1	As per programme no.			2 slot
2	Gun Drilling Work Completed On			32 mm width
3	Hole Finish In Gun Drilling	Marked	ok	8 mm Deep
4	Defective Holes (If Any)		No	Both Side

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 mm	Outside (3-3)		Inner				
3	External Relief Depth	✓	24 mm		20 mm				
4	Inspection Done Before Hardening By (Name)			✓	Ravi				
5	Material Sent For Hardening By (Name)				Lark Purrore				
6	Material Sent For Hardening On Date			21	9	24			

Inspected By (Sign) & Date

Ravi 21/9/24

Reviewed by (Engineer-CNC)
 Sot... 21/9/24

Manager-QA