



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.		12879 ✓	45/50 ✓
2	Machined By		V.T.L. n/c Shop	Dr. No. L&C/10969
3	Pallet Die No.		13373 (4.0) n/c	Rev=01 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	76mm Step 002 792mm	Step length 27mm
6	Inside Diameter	Drg. No.	66.012 mm	Under cut = 16mm
7	Width of Pellet Die	Drg. No.	324 mm	
8	Grooves as per Drawing	Drg. No.	21x8x10 mm 21x8x10 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 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: 27.4 mm	Tapping Depth: 25.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/9/24

1	As per programme no.			2 Slot 32.1 mm dia width 9 mm Deep 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, 60 Rov=47	
2	External Relief Dia	4.5 mm	outside (2-3)		Inner				
3	External Relief Depth		13 mm		5 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		23	9	24				
Inspected By (Sign) & Date			Ravi 23/9/24						

Reviewed by (Engineer-CNC)
Sato 23/9/24

Manager-QA