



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 ✓	45/65 ✓
2	Machined By		V. T. L. H/C Shop	Dy. No. 18.0.1151
3	Pallet Die No.		12983 (8.0) ✓	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790mm Step 002 798mm	Tabben 40
6	Inside Diameter	Drg. No.	660.12mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	323.8mm	Load cut 4mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10mm / 21.5 x 8 x 10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of holes 12 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 30.4mm	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 31/07/24	2 SLOT 32.1mm wide 8mm Deep Both Side
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	
<p>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</p> <p>Counter 60</p>				
1	Counter Sinking Depth & Finish	OK		Rep: 27
2	External Relief Dia	8.5mm	outside (3-3)	Inner
3	External Relief Depth		28mm	20mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		3 10 24	
Inspected By (Sign) & Date			Ravi 31/07/24	

Reviewed by (Engineer-CNC) *Satyam 31/07/24*

Manager-QA