



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	45/85
2	Machined By		V. T. L. n/c Shop	Dy No. 13.0.1151
3	Pallet Die No.		12984(8.0)mm	Renew
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790mm Step OD: 798mm	Tabber 4
6	Inside Diameter	Drg. No.	660.12 mm	Step length: 25.5
7	Width of Pellet Die	Drg. No.	323.8mm	Undercut: 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		n/c Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20: Check by M20 Ball	
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

1	As per programme no.			2 Slot 32.1mm width 8mm 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

Counter G

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	8.5mm	Outside (3-3)		Inner					
3	External Relief Depth		28mm		20mm					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		03	10	24					
Inspected By (Sign) & Date		Ravi 31/07/24								

Reviewed by (Engineer-CNC)
Sotya 31/07/24

Manager-QA