



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.		12970	30/66
2	Machined By		V.T.L. N/C Shop	27/66
3	Pallet Die No.		13338 (G ₁₀)	Drg No. 132 B2
4	Die Category	Drg. No.	Mr. Jumbo	Rev. 08
5	Out Side Diameter	Drg. No.	680.1 mm	Step 02 - 693 mm
6	Inside Diameter	Drg. No.	546.12 mm	Boor 2 548.1 mm
7	Width of Pellet Die	Drg. No.	195	Step length 314
8	Grooves as per Drawing	Drg. No.	327 779.1 mm	Under cut 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32-779.1 mm	(C4-2) mm
10	Drilling Area Surface Smoothness		ok	Face side step groove Dist. Bm
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 mm	Tapping No of holes 2
13	Tapping Hole Diameter		N/C 2	
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth - 34.8 mm	Tapping Depth - 30 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/12/24

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

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

1	Counter Sinking Depth & Finish	ok				Counter B ₀
2	External Relief Dia	7.0 mm	1st Pad	2nd Pad		Row 2-12
3	External Relief Depth		38 mm	39 mm		
4	Inspection Done Before Hardening By (Name)					Ravi
5	Material Sent For Hardening By (Name)					Lark Personnel
6	Material Sent For Hardening On Date		11	10	24	

Inspected By (Sign) & Date

Ravi 11/12/24

Reviewed by (Engineer-CNC)

Manager-QA