



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

8900

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12968	55/66
2	Machined By		V.T.L. N/C Shop	Dyals: 63.0.1095
3	Pallet Die No.		12933 (8.0) mm	Rev: 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	68.0 mm	Step 00 - 69.5 mm
6	Inside Diameter	Drg. No.	54.7.9 mm	Tapper: 5"
7	Width of Pellet Die	Drg. No.	215 mm	Step length: 38 mm
8	Grooves as per Drawing	Drg. No.	30.5 x 6 x 8.1 mm	Under cut: 3.15 mm
9	Fitting Sizes on CNC Plate	Drg. No.	30.5 x 6 x 8.1 mm	(6 x 8) mm
10	Drilling Area Surface Smoothness		OK	[Race Side Step]
11	Tapping Operator		N/C Shop	[14 - Deep Both Side]
12	Tapping PCD		68.0 mm	[Tapping No.]
13	Tapping Hole Diameter		N/C - Check by N/C Bolt	[of holes: 2]
14	Tapping On Second Side	Half pitch of 1st side	OK	[Both Side]
15	Tapping Hole Depth		Drill Depth = 32.7 mm	Tapping Depth: 30.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/10/24

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

Counter: 20

1	Counter Sinking Depth & Finish	OK						Row: 12
2	External Relief Dia	9.0 mm		All Rows				
3	External Relief Depth			11 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		18	10	24			

Inspected By (Sign) & Date

Ravi: 18/10/24

Reviewed by (Engineer-CNC)

Manager-QA