



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.		13190	30/38/62
2	Machined By		V.T.L. n/c. Shop	Drg. No. 130797
3	Pallet Die No.		13805 (4.8mm)	Rev. No.
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 mm	
6	Inside Diameter	Drg. No.	Step 0.02 790 mm	Step lengths 28.5
7	Width of Pellet Die	Drg. No.	660.12 mm	Under cut 2.6 mm
8	Grooves as per Drawing	Drg. No.	324 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 mm 21.5 x 8 x 8 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	
12	Tapping PCD		725 mm	Tapping dia of Holes = 12 Peta Side
13	Tapping Hole Diameter		M20 x 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.4 mm	Tapping Depth 29.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi: 29/10/24

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

Counters = 30

Rows = 47

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.8 mm 5.0 mm	4.8 mm	All Rows = 30 mm			
3	External Relief Depth		5.0 mm	All Rows = 22			
4	Inspection Done Before Hardening By (Name)			Rasi			
5	Material Sent For Hardening By (Name)			Lark Ravnare			
6	Material Sent For Hardening On Date		29	10	24		

Inspected By (Sign) & Date

Rasi: 29/10/24

Reviewed by (Engineer-CNC)

Manager-QA