



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.		13424	37145
2	Machined By		V.T.L. N/C Shop	Dry No. 12021543
3	Pallet Die No.		12512 (3.0) mm	Rev. 100
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610 mm / Step 612 mm	Step length 20 mm
6	Inside Diameter	Drg. No.	520.12 mm	Under cut 1 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		56.5 mm	Tapping No. of holes = 12 Both Side
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 = 20.4 mm	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/11/24

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					Count 22 = 60
2	External Relief Dia	3.5 mm	Outside (3-3)	Inner			Row = 38
3	External Relief Depth		14 mm	8 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		25	11	24		

Inspected By (Sign) & Date

Ravi 25/11/24

Sachin 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA