



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9654	30/55/90
2	Machined By		V.T.L. N/A Shop	Drg No. 1.3.0.659
3	Pallet Die No.		10370 (G.O)	Rev: 03
4	Die Category	Drg. No.	M740	
5	Out Side Diameter	Drg. No.	752 mm Step 002 777 mm / 776 mm / 675 mm	
6	Inside Diameter	Drg. No.	578.12 mm	Step length 48 mm / 24.5
7	Width of Pellet Die	Drg. No.	870 mm	Undercut 19.5 mm
8	Grooves as per Drawing	Drg. No.	88x8x12 mm / 106x8x12 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No of Holes: 6
12	Tapping PCD		660 mm	
13	Tapping Hole Diameter		081/4" - Check by 031/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 2nd Side Check	
15	Tapping Hole Depth		Drill Depth: 35.4 mm	Tapping Depth: 33.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/6/23

1 SLOT
39.1 mm width
26 mm Deep

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 Go

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Lines	7.0 mm All Lines					
3	External Relief Depth		6.0 mm	3.5 mm					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark For more						
6	Material Sent For Hardening On Date		13	6	25				

Inspected By (Sign) & Date

Ravi 13/6/23

Reviewed by (Engineer-CNC)

Manager-QA