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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.		14011	32/42/55
2	Machined By		V.T.L M/c Shop	Drwg No. 23.D.407
3	Pallet Die No.		14100 (4.D) mm	Rev. 00
4	Die Category	Drg. No.	M/JumBo	
5	Out Side Diameter	Drg. No.	710 mm, Step OD. 693 mm	Step Length 22 mm
6	Inside Diameter	Drg. No.	600: 12 mm	Tapper-12°
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12X8X7 mm / 12X8X7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Hols. 12 Both Side
12	Tapping PCD		640 mm	
13	Tapping Hole Diameter		M.20 check by M.20 Bolts	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 202 mm Tapping Depth 186	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 29/1/25	
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-60°

Rough-32

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia		Undercut All Relief		Finish	Shoulder		
3	External Relief Depth		Ø4.5 mm-23 mm			Ø5.0 mm-13 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		29	1	25			
	Inspected By (Sign) & Date		Ravi 29/1/25					

Satbir 29/1/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner