



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.		9674	25/45/60
2	Machined By		V.T.C. n/c Shop	1. y n/c 1. S. D. 111
3	Pallet Die No.		10504 (G.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c	Step 0.07 792 n/c
6	Inside Diameter	Drg. No.	660.12 n/c	Step length 29.5
7	Width of Pellet Die	Drg. No.	324 n/c	Undercut 2.6 n/c
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	
12	Tapping PCD		725 n/c	Tapping No of holes 12 Both side
13	Tapping Hole Diameter		H20 3 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.4 n/c	Tapping Depth 29.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/6/23

1	As per programme no.			2 SLOT 32.1 n/c width 8 n/c Deep Both side
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								Row 2 34
2	External Relief Dia	6.5 n/c	6.75 n/c	6.5 n/c	All Lines	6.75 n/c	All Lines			
3	External Relief Depth				35 n/c		15 n/c			
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date				17	6	23			
Inspected By (Sign) & Date		Ravi 17/6/23								

Reviewed by (Engineer-CNC)

Manager-QA