



# 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.		14195 ✓	38/45 ✓
2	Machined By		V.T.L. H/O Shop	Drg No. 13.02-579
3	Pallet Die No.		13847 (3.0) ✓	Rev 201 ✓
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610 mm, Step OD - 615.5 mm	Tapp hole 4°
6	Inside Diameter	Drg. No.	58.12 mm	Step length 20 mm
7	Width of Pellet Die	Drg. No.	222 mm	Under cut 2.75 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		H/O Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Tapping No. of holes = 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 mm	Tapping Depth 18.8 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 15/2/25

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

1	Counter Sinking Depth & Finish	ok						Counter 60° Rev 2 38
2	External Relief Dia	3.5 mm	Outside (3-3)		Inner			
3	External Relief Depth		13 mm		7 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Forncore
6	Material Sent For Hardening On Date		15	2	25			

### Inspected By (Sign) & Date

Ravi 15/2/25

Ravi 15/2/25

Reviewed by (Engineer-CNC)

Manager-QA