



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.		10209	42/58
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.2.6986
3	Pallet Die No.		11012 (3.0)mm	Rep = 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	776mm Step OD, 800mm	Step length 20mm
6	Inside Diameter	Drg. No.	66.12mm	Under cut = 12mm
7	Width of Pellet Die	Drg. No.	316mm	
8	Grooves as per Drawing	Drg. No.	20x8x7.5mm / 20x8x7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No of holes = 12 Both Side
12	Tapping PCD		725mm	
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 25.6mm Tapping Depth 23.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 4/9/22

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 - 1 Hole Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK							Rep = 57
2	External Relief Dia	3.5mm	Outside (3-3)		Inner				
3	External Relief Depth	✓	22mm		16mm				
4	Inspection Done Before Hardening By (Name)		✓	Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		4	9	23				

Inspected By (Sign) & Date Ravi 4/9/23

Reviewed by (Engineer-CNC) 4/9/23

Manager-QA