



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.		10263	40/60/150
2	Machined By		V.T.L. H/c Shop	Drg No. 13.0.986
3	Pallet Die No.		11193	Rev 200
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1050 H/H, Step 002, 1048 H/H	Tappers 4°
6	Inside Diameter	Drg. No.	850.12 H/H 850.11 One Tapper	Step length 30.5
7	Width of Pellet Die	Drg. No.	251 H/H	
8	Grooves as per Drawing	Drg. No.	50x10x12 H/H 50x11x12 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No of holes = 24 Both Side
12	Tapping PCD		958 H/H	
13	Tapping Hole Diameter		M30 - Check by M30 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 43.5 H/H	Tapping Depth 41.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/10/23

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 60°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	8.5 H/H 9.5 H/H	8.5 H/H All Lines	9.5 H/H All Lines						
3	External Relief Depth	/ /	60 H/H	40 H/H						
4	Inspection Done Before Hardening By (Name)		Ravi							
5	Material Sent For Hardening By (Name)		Lark Purchase							
6	Material Sent For Hardening On Date		18	10	23					

Inspected By (Sign) & Date

Ravi 18/10/23

Satyam 18/10/23

Reviewed by (Engineer-CNC)

Manager-QA