



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.		9947	60/60
2	Machined By		N.T.L. n/c Shop	Drg No. L.S.D. 584
3	Pallet Die No.		11036 (10.0) mm	Rev. 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 mm, Step 002 798 mm	Tapper = 4°
6	Inside Diameter	Drg. No.	660.12 mm	Step length = 25.5
7	Width of Pellet Die	Drg. No.	324 mm	Under cut = 9 mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm 21.5 x 8 x 10 mm	
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		725 mm	
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: 30.4 mm Tapping Depth: 28.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date		Ravi 20/10/23		2 SLOT	
1	As per programme no.			32 mm wide	
2	Gun Drilling Work Completed On			8 mm Deep	
3	Hole Finish In Gun Drilling	Marked	ok	Both Side	
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							Rev: 19
2	External Relief Dia			No - Relief					
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Keshav					
6	Material Sent For Hardening On Date		20	10	23				

Inspected By (Sign) & Date

Ravi 20/10/23

Reviewed by (Engineer-CNC)
Sahj 20/10/23

Manager-QA