



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.		10393 ✓	L10/50/70 ✓
2	Machined By		V.T.L n/c Shop	Dy. No. 15.0 877 ✓
3	Pallet Die No.		10576 (8.0) 44 ✓	Rev 203 ✓
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm / Step 00. 697.7 mm, Tappers 5°	
6	Inside Diameter	Drg. No.	548.12 mm / 548.14	Step length 38.5 mm
7	Width of Pellet Die	Drg. No.	215 mm	Under Cut 1.79 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 1078 mm / 29.5 x 1078 mm (Q78) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Step 1 mm Deep Both Side
11	Tapping Operator		N/C Shop	
12	Tapping PCD		618 mm	Tapping No
13	Tapping Hole Diameter		M16 Check by M16 Bolt	of Hole 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 38.4 mm Tapping Depth 30.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Paoi 19/10/23

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

1	Counter Sinking Depth & Finish	OK						Counter 2 30° Low 12
2	External Relief Dia	8.5 mm / 9.0 mm	8.5 mm All Lines	9.0 mm All Lines				
3	External Relief Depth		30 mm	20 mm				
4	Inspection Done Before Hardening By (Name)		Paoi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		19	10	23			

Inspected By (Sign) & Date Paoi 19/10/23

Reviewed by (Engineer-CNC) Satyam 19/10/23

Manager-QA