



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.		9810	
2	Machined By		V.T.L. w/c Shop	45/50
3	Pallet Die No.		10303 (C4.0) w/c	Dry Nos L.S.O 403
4	Die Category	Drg. No.	Senior	Rev. 2.00
5	Out Side Diameter	Drg. No.	520 mm	
6	Inside Diameter	Drg. No.	Step 10.0 49	Step length 2.4
7	Width of Pellet Die	Drg. No.	420.1 mm	
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm / 12x8x3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		w/c Shop	Tapping No. of holes: 8 Both side
13	Tapping Hole Diameter		454 mm	
14	Tapping On Second Side	Half pitch of 1st side	φ3/4" 2 Check by φ3/4" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.4 mm	Tapping Depth = 16.8 mm
17	Visual Inspection Before Gun Drilling		yes ok	
Inspected By (Sign) & Date				
1	As per programme no.			Ravi 28/6/23
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		ok No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	4.5 mm	outside (2-2)	Inner
3	External Relief Depth	✓	13 mm	5 mm
4	Inspection Done Before Hardening By (Name)			Ravi ✓
5	Material Sent For Hardening By (Name)			Lark Ravi
6	Material Sent For Hardening On Date		28 6 23	
Inspected By (Sign) & Date				
				Ravi 28/6/23

Reviewed by (Engineer-CNC)

Manager-QA