



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		V.T.L. H/C Shop	Drg No. L.S.D. 584
3	Pallet Die No.		11040 (10.0) H/C	Revised
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm Step 002 798mm	Tapper = 4°
6	Inside Diameter	Drg. No.	660.14mm	Step length = 25.5
7	Width of Pellet Die	Drg. No.	324mm	Under cut = 9mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		725mm	Tapping No. of holes = 12 Both Side
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 30.4mm	Tapping Depth 28.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/10/23

1	As per programme no.			2 Slot 32mm width 8mm Deep Both Side
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							Row = 19
2	External Relief Dia								
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 23/10/23

27/10/23

Reviewed by (Engineer-CNC)

Manager-QA