



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.		10543	30/45/55
2	Machined By		V.T.L n/c Shop	Py 2.2 L.S.C. 18/8/13
3	Pallet Die No.		11013 (G.) n/c	Rev 2.00
4	Die Category	Drg. No.	End side	
5	Out Side Diameter	Drg. No.	630 n/c Step OD = 612 n/c	Step length = 19.4
6	Inside Diameter	Drg. No.	590.12 n/c	
7	Width of Pellet Die	Drg. No.	221.8 n/c	
8	Grooves as per Drawing	Drg. No.	13x8.5 n/c 13x8.5 n/c	
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		565 n/c	
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 20.0 n/c Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/10/23

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								Ravi 23
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c All Cms	7.0 n/c All Cms						
3	External Relief Depth		25 n/c		10 n/c					
4	Inspection Done Before Hardening By (Name)		Ravi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		31	10	23					

Inspected By (Sign) & Date

Ravi 31/10/23

Reviewed by (Engineer-CNC)

Manager-QA