



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.		9776	45/55
2	Machined By		V.T.L. n/c Shop	Drg No. L.S.O. 839
3	Pallet Die No.		7994(3.5)mm	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	810mm, Step 00, 801mm	Tap 4°
6	Inside Diameter	Drg. No.	700.12mm	Step length = 27mm
7	Width of Pellet Die	Drg. No.	369.8mm	
8	Grooves as per Drawing	Drg. No.	25x10x9mm / 25x10x9mm	
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		750mm	
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 = 35.2mm	Tapping Depth = 33.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi: 29/6/23

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							Low = 59
2	External Relief Dia	4.0mm	Outside (3-3)		Inner				
3	External Relief Depth		17mm		10mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		29	6	23				

Inspected By (Sign) & Date

Ravi: 29/6/23

Reviewed by (Engineer-CNC)

Manager-QA