



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.			
2	Machined By		9844	36/50
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 12.D.419
4	Die Category	Drg. No.	9688 (3.0) H/c	Rev 2.00
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	700 H/c Step OD: 692 H/c	Step length: 19.4
7	Width of Pellet Die	Drg. No.	600.12 H/c	
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12.5 x 8 x 7 H/c 12.4 x 8 x 7 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		645 H/c	Tapping No. of Holes: 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Belt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 22.4 H/c	Tapping Depth: 20.7
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 1/7/23

1	As per programme no.	
2	Gun Drilling Work Completed On	
3	Hole Finish In Gun Drilling	Marked
4	Defective Holes (If Any)	ok

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	3.5 H/c	Outside (3-3)			Low F 38
3	External Relief Depth		20 H/c	Inner	14 H/c	
4	Inspection Done Before Hardening By (Name)					
5	Material Sent For Hardening By (Name)			Ravi		
6	Material Sent For Hardening On Date			Lark Furnace		
Inspected By (Sign) & Date						

Ravi 1/7/23

Reviewed by (Engineer-CNC)

Manager-QA