



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.		10988	110/55
2	Machined By		V.T.L. N/C Shop	129 Nos 1.2.5.1 1951
3	Pallet Die No.		11359 (8.0) H	Rev. 1.00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	630 H Step 00, 621.4 H	Tapper = 12
6	Inside Diameter	Drg. No.	520.14 H	Step length = 9.5
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H / 13x8x5 H	
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 Back Side
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 21.4 H Tapping	Depth = 19 H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/1/24

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

Count as 60°

1	Counter Sinking Depth & Finish	ok							Rev = 18
2	External Relief Dia	8.5 H	Outside (2-3)		Inner				
3	External Relief Depth		23 H		17 H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		8	1	-24				

Inspected By (Sign) & Date

Ravi 8/1/24