



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.		11050	36/45/55
2	Machined By		V.T.L.N/C Shop	By H20: 1.8.0.4
3	Pallet Die No.		11632 (4.0) H2	Rev: 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 H2	Step length: 9.4
6	Inside Diameter	Drg. No.	600.14 H2	
7	Width of Pellet Die	Drg. No.	222 H2	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H2 12.5 x 8 x 7 H2	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping H- of holes = 12 Roth Side
12	Tapping PCD		645 H2	
13	Tapping Hole Diameter		H20, Check by H20, Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 23 H2	Tapping Depth: 20.8 H2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/1/24

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

1	Counter Sinking Depth & Finish	ok					Counter = 60°
2	External Relief Dia	4.5 H2 / 5.0 H2	4.5 H2 All Rows	5.0 H2	All Rows		Rev: 32
3	External Relief Depth		19 H2		10 H2		
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		12	1	24		

Inspected By (Sign) & Date

Ravi 12/1/24

Satyam 12/1/24

Reviewed by (Engineer-CNC)

Manager-QA