



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.		11034	32/40/50
2	Machined By		V.T.L n/c Shop	Drg No. 1.8.0-059
3	Pallet Die No.		11867 (4.0)mm	Rev 02
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	62mm Step 002 622.5mm	Tapper 12°
6	Inside Diameter	Drg. No.	520.12mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	222mm	Under cut -1.25mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping dia of holes = 12 Both Side
12	Tapping PCD		565mm	
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 = 21.3mm Tapping Depth = 19mm	
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° Lead = 31
2	External Relief Dia	4.3mm / 4.8mm	4.3mm	All Rows	4.8mm	All Rows	
3	External Relief Depth		18mm		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		12	1	24		

Inspected By (Sign) & Date Ravi 12/1/24

[Signature]
Reviewed by (Engineer-CNC)

Manager-QA