



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.		11014	45/60
2	Machined By		V. T. L. n/c Shop	Drill No. 13.0 584
3	Pallet Die No.		11001 (28.0) n/c	Rev = 01
4	Die Category	Drg. No.	70mm	
5	Out Side Diameter	Drg. No.	780mm, Step 00 = 798mm	Tapper = 4°
6	Inside Diameter	Drg. No.	660.12mm	Step length = 25.5
7	Width of Pellet Die	Drg. No.	324mm	Under out = 9mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10mm / 21.5 x 8 x 10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of holes = 12 Both Side
12	Tapping PCD		725mm	
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 = 31.3mm	Tapping Depth = 28.8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/11/24

1	As per programme no.			2 Slot 32.1mm width 8mm Deep Both Side
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

Counters 6°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5mm	outside (2-3)	Inner					
3	External Relief Depth		23mm	15mm					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Formare						
6	Material Sent For Hardening On Date		23	1	24				

Inspected By (Sign) & Date

Ravi 23/11/24

Reviewed by (Engineer-CNC)

Manager-QA