



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.		11238	40/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 12-01-25-1
3	Pallet Die No.		11214 (3.5) n/c	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	(A)
5	Out Side Diameter	Drg. No.	700 n/c Shop OD = 892.8mm	Tappers 12
6	Inside Diameter	Drg. No.	600.12 n/c	Shop length 10mm
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c 12x8x7 n/c	
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 Both side
12	Tapping PCD		640mm	
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 = 21.4mm Tapping Depth = 19mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/8/24

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 - 1 Hole Colored (A)

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

Counter = 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.0mm	Outside (3.3)	Inner						
3	External Relief Depth		17mm	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		15	8	24					

Inspected By (Sign) & Date

Ravi 15/8/24

Reviewed by (Engineer-CNC)

Manager-QA