



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.		10583	31/45/60
2	Machined By		V. T.L. n/c Shop	Dignity L.S.D. 469
3	Pallet Die No.		11727 (3.5) n/c	Rev 2.02
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c, 3rd step 002 932 n/c / 718 n/c	
6	Inside Diameter	Drg. No.	660.12 n/c / 10 Step 2 670.1 n/c	Step length 30 n/c
7	Width of Pellet Die	Drg. No.	331.4 n/c	Under cut = 76 n/c
8	Grooves as per Drawing	Drg. No.	46 x 7 x 9.5 n/c 41.4 x 7 x 9.5	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping H. of holes = 4
11	Tapping Operator		n/c: Shop	
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		M202 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Top Side 3 Slot	
15	Tapping Hole Depth		Drill Depth 31 n/c Tapping Depth 28.4 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/8/24

1	As per programme no.			3 Slot 371 mm width 20.5 mm Depth
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 4 Hole Colored	

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	4.0 n/c / 4.5 n/c	4.0 n/c All Rows	4.5 n/c All Rows				
3	External Relief Depth		29	15 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		21	2	24			

Inspected By (Sign) & Date

Ravi 21/8/24

Satish 21/8/24