



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

7017

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11383 ✓	40/50
2	Machined By		V.T.L. n/c Shop	Drilling 1-20-493
3	Pallet Die No.		11217 (4.0) ✓	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	⊙
5	Out Side Diameter	Drg. No.	700mm, Step 002-6923mm, Tapper, 12°	
6	Inside Diameter	Drg. No.	600.12mm	Step length 19.8
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12x10x7.5mm / 12x10x7.5mm	
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 - 21.3mm Tapping Depth - 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/7/24

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	4.5mm	Outside (3-3)	Inner				Low - 31
3	External Relief Depth		14mm	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		22	2	24			

Inspected By (Sign) & Date

Ravi 22/7/24

Satish 21/7/24

Reviewed by (Engineer-CNC)

Manager-QA