



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.		11301	40/50/70
2	Machined By		V.T.L. n/c Shop	Dy. No. 1.3.0.377
3	Pallet Die No.		10748 (8.0) mm	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 mm, Step 002 697.7 mm	Tapper 5°
6	Inside Diameter	Drg. No.	548.12 mm	Step Length 38.5
7	Width of Pellet Die	Drg. No.	915 mm	Under cut = 1.75
8	Grooves as per Drawing	Drg. No.	29.5 x 1048 mm / 29.5 x 1048 mm	(6 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	1 mm Deep Back Side
11	Tapping Operator		n/c Shop	Tapping No. of holes: 2
12	Tapping PCD		618 mm	Back Side
13	Tapping Hole Diameter		mm H16 = Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33 mm	Tapping Depth 30.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/3/24

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 3°
2	External Relief Dia	8.5 mm / 9.0 mm	8.5 mm	All Rows	9.0 mm	All Rows	
3	External Relief Depth		30 mm		20 mm		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		4	3	24		
Inspected By (Sign) & Date		Ravi 4/3/24					

Satya 4/3/24

Reviewed by (Engineer-CNC)

Manager-QA