



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.		11384	30/38/65
2	Machined By		V.T.L n/c Shop	Dry Wood L.S.O. 988
3	Pallet Die No.		11936 (4.0) MM	Rec 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 MM Step 00: 792 MM	Step length 28.5
6	Inside Diameter	Drg. No.	660.14 MM / 660.2 MM (A)	Under cut = 1 MM
7	Width of Pellet Die	Drg. No.	324 MM	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 MM / 21.5 x 8 x 8 MM	
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		725 MM	
13	Tapping Hole Diameter		M20 Check by H20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 31.7 MM Tapping Depth 29.6 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 13/3/24

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						Counters = 30
2	External Relief Dia	4.5 MM / 5.0 MM	4.5 MM All Rows	5.0 MM All Rows				Row = 47
3	External Relief Depth		35 MM	27 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		13	3	24			

Inspected By (Sign) & Date Ravi 13/3/24

Saxena
13/3/24
Reviewed by (Engineer-CNC)

Manager-QA