



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.		11629 ✓	40/66
2	Machined By		V.T.L. n/c Shop	45/66 ✓
3	Pallet Die No.		12036 (8.0) n/c	Dy No. 13.02.609
4	Die Category	Drg. No.	M. Jumbo	Rev. 01
5	Out Side Diameter	Drg. No.	680.7 n/c	Step 002 693 n/c
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 2.1 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c	32 x 7 x 8 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 = 4 Back Side
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.8 n/c	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 11/4/24*

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 30° Row = 10
2	External Relief Dia	9.0 n/c	1st Pad	2nd Pad			
3	External Relief Depth		26 n/c	21 n/c			
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>				
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>				
6	Material Sent For Hardening On Date		1	4	24		
Inspected By (Sign) & Date			<i>Ravi 11/4/24</i>				

Reviewed by (Engineer-CNC) *Satyam 11/4/24*

Manager-QA