



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.		11631	60/60
2	Machined By		V.T.L. H/c Shop	1 Dry Hole 68.02 413
3	Pallet Die No.		11560 (5.0) H/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	7.20 H/c Step OD = 69.7 H/c	Tapper 12"
6	Inside Diameter	Drg. No.	600.12 H/c (Inner Rad 17.5)	Step length 19.5
7	Width of Pellet Die	Drg. No.	222.3 H/c	
8	Grooves as per Drawing	Drg. No.	14x8x7 H/c / 13.7x8x7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping Hole of Hole 22.12 Both Side
12	Tapping PCD		640 H/c	
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 22.7 H/c	Tapping Depth 20.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 3/4/24

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

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.5MM	Outside (3-3)		Inner				
3	External Relief Depth	/	10MM		Null				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		3	4	24				

Inspected By (Sign) & Date

Ravi 3/4/24