



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.		11705	50/53/65
2	Machined By		V.T.L. H/C Shop	Dr. W. ...
3	Pallet Die No.		11519 (3.8) H/H	Rev. ...
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 H/H Step 00, 822.6 H/H	Tabber, 40
6	Inside Diameter	Drg. No.	700.12 H/H	Step Length, 33 H/H
7	Width of Pellet Die	Drg. No.	324 H/H	
8	Grooves as per Drawing	Drg. No.	30x8x8.5 H/H / 30x8x8.5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 12 Rota Side
12	Tapping PCD		760 H/H	
13	Tapping Hole Diameter		M22 = Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 36.4 H/H	Tapping Depth 33.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Rasi 16/4/24

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. Co. Row 240
2	External Relief Dia	4.3 H/H / 4.8 H/H	4.3 H/H All Rows	4.8 H/H All Rows		
3	External Relief Depth		15 H/H	7 H/H		
4	Inspection Done Before Hardening By (Name)		Rasi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		16	4	24	

Inspected By (Sign) & Date Rasi 16/4/24

Reviewed by (Engineer-CNC) Soti 16/4/24

Manager-QA