



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.		11193	45/50
2	Machined By		V.T.L. n/c Shop	Drg. No. 1.2.0.9980
3	Pallet Die No.		11596(4.0) n/c	Rev. No.
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	62mm, Step 00, Tappers 12°	
6	Inside Diameter	Drg. No.	52.12 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	22.2 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		56.5 mm	Tapping no. of holes 12
13	Tapping Hole Diameter		14mm, Check by no. 2	Bolt Bolt side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 mm	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/5/24

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								Count on 60
2	External Relief Dia	4.5 mm	outside (3-3)		inner					Count 31
3	External Relief Depth		13 mm		5 mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Ramace
6	Material Sent For Hardening On Date			9	5	24				

Inspected By (Sign) & Date

Ravi 9/5/24

Reviewed by (Engineer-CNC)

Manager-QA