



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.		11895	33/45
2	Machined By		V.T.L. n/c Shop	Dry Hole 1.3.0. 736
3	Pallet Die No.		11830 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	690.5 n/c Step 0.2, 693 n/c	Tabber 12°
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 20mm
7	Width of Pellet Die	Drg. No.	222 n/c	Under cut 1.25mm
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c / 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Hole 12° Retn Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		N 20 - Check by H 20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/5/24

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						Counter 60° Row 239
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner			
3	External Relief Depth		18 n/c		18 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		8	5	24			

Inspected By (Sign) & Date

Ravi 8/5/24

Reviewed by (Engineer-CNC)

Manager-QA