



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.		9823	30/50/66
2	Machined By		V.T.L n/c Shop	Dry No. 1.8.9.809
3	Pallet Die No.		9893 (6.0) n/c	Rev 2.01
4	Die Category	Drg. No.	M. Tumbo	
5	Out Side Diameter	Drg. No.	380.69 n/c Step 00. 692 n/c	Step length 2.81 n/c
6	Inside Diameter	Drg. No.	548.14 n/c	Tapper 2 8°
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32x7x8 n/c 32x7x8 n/c	(4x8) Face side step 2 n/c Both Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		NIG 2 Check by NIG Bolt	Tapping No. of holes = 4 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33 n/c Tapping Depth = 31.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/8/23

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°
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c All Lines	7.0 n/c All Lines			Rev 2.12
3	External Relief Depth		36 n/c	16 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	8	23		

Inspected By (Sign) & Date

Ravi 8/8/23

Reviewed by (Engineer-CNC)

Manager-QA