



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.		12829	30/66
2	Machined By		V.T.L. H/C Shop	Dy. No. 13.0. B30
3	Pallet Die No.		13327 (G.S.) H/C	Rev. 05
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.14 H/C	Step 00, 693.1 H/C
6	Inside Diameter	Drg. No.	548.1 H/C	Step length 31mm
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut = 2.5mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/C	(408) H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	2mm Deep Back side
11	Tapping Operator		H/C Shop	Tapping No. of holes 4
12	Tapping PCD		619 H/C	Back side
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 34.8 H/C	Tapping Depth 31.8 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/9/24

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 30
2	External Relief Dia	7.0 H/C	All Rows					Row 12
3	External Relief Depth		36 H/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		14	9	24			

Inspected By (Sign) & Date

Ravi 14/9/24

Satya 14/9/24

Reviewed by (Engineer-CNC)

Manager-QA