



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.		12955	35/4/66
2	Machined By		V. T. L. H/C Shop	Dy. No. L.S.D. 609
3	Pallet Die No.		13322 (6.0) H	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H Step 0.0, 673 H	Tabbers 8
6	Inside Diameter	Drg. No.	548.1 H	Step length 31 H
7	Width of Pellet Die	Drg. No.	195 H	Under cot 2.5 H
8	Grooves as per Drawing	Drg. No.	32x7x8 H 32x7x8 H (4x8) H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 H Deep Back Side
11	Tapping Operator		H/C Shop	Tapping H
12	Tapping PCD		619 H	of Holes id
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 34.8 H Tapping Depth 32 H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Pass: 8/10/24

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 2 30
2	External Relief Dia	6.5 H / 7.0 H	6.5 H All Rows	7.0 H All Rows			Row 12
3	External Relief Depth		31 H	28 H			
4	Inspection Done Before Hardening By (Name)		Pass				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		8	10	24		

Inspected By (Sign) & Date

Pass: 8/10/24

Reviewed by (Engineer-CNC)

Manager-QA