



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.		12956	28/38/66
2	Machined By		V. T.L. n/c Shop	Drg No. 1.8.0-809
3	Pallet Die No.		13335 (6.0) n/c	Revised
4	Die Category	Drg. No.	M. Jowho	
5	Out Side Diameter	Drg. No.	680.7 n/c Step OD = 693 n/c	Tabber 8°
6	Inside Diameter	Drg. No.	547.12 n/c 547.9 n/c	Step length = 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8 n/c (4 x 8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Step & n/c Tap
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		619 n/c	Tapping No.
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	of Holes &
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth = 34.8 n/c	Tapping Depth = 32 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/10/24

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

Counter = 30

1	Counter Sinking Depth & Finish	OK							Row = 12
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c All Rows	7.0 n/c All Rows					
3	External Relief Depth		38 n/c	38 n/c					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		14	10	24				

Inspected By (Sign) & Date

Ravi 14/10/24

Reviewed by (Engineer-CNC)

Manager-QA