



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks	
1	Work Order No.		12636 ✓	6066 ✓	
2	Machined By		V. T. C. H/c Shop	Drg No. 62029136	
3	Pallet Die No.		13513 (3.5) H/c ✓	Revol ✓	
4	Die Category	Drg. No.	S. Jumbo		
5	Out Side Diameter	Drg. No.	1032 H/c, Step 002 1033 H/c	Tapper 3°	
6	Inside Diameter	Drg. No.	900.14 H/c / 900.3 H/c (A)	Step length 37 H/c	
7	Width of Pellet Die	Drg. No.	375 H/c	Under cut 0.5 H/c	
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 H/c / 29.5 x 8 x 13 H/c		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		H/c Shop	Tapping H/c of holes 15 Both Side	
12	Tapping PCD		970 H/c		
13	Tapping Hole Diameter		M24: Check by M24 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth 38.4 H/c	Tapping Depth 36 H/c	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 15/10/24	2 Slot 32 H/c width 7.5 H/c Deep Both Side	
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 = 6° Ravi = 59	
2	External Relief Dia	4.0 H/c	Outside 4-45	Inner	
3	External Relief Depth		13 H/c	6 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		15	10	24
Inspected By (Sign) & Date			Ravi 15/10/24		

Reviewed by (Engineer-CNC)

Manager-QA