



Lark Engineering Company (India) Pvt. Ltd.

111 Subordi 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		13154	30/66
2	Machined By		V.T.C H/c Shop	Dg No. 189.330
3	Pellet Die No		13620 (6.0) mm	Row 23
4	Die Category	Dr. No.	H. Jumbo	
5	Out Side Diameter	Dr. No.	680.1 mm	Step 00: 693.1 mm
6	Inside Diameter	Dr. No.	548.1 mm	Step length: 31 mm
7	Width of Pellet Die	Dr. No.	195 mm	Under cut: 2.3 mm
8	Grooves as per Drawing	Dr. No.	32 x 7.99 mm	(4 x 8 mm)
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side Step 31 mm
11	Tapping Operator		H/c Shop	Deep Back side
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Ball	Tapping No. of holes: 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth: 33.6 mm	Tapping Depth: 315
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/10/24

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: 30
2	External Relief Dia	7.0 mm	All Rows					Row 212
3	External Relief Depth			36 mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		29	10	24			

Inspected By (Sign) & Date

Ravi 29/10/24

Reviewed by (Engineer-CNC)

Manager-QA