



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.		13154 ✓	30/66 ✓
2	Machined By		V.T.L. M/c Shop	Drilled (3.0-3.2)
3	Pallet Die No.		13681 (6.0) M/c	Rev 208
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 M/c → Step no. 393 M/c	→ Tapper 3°
6	Inside Diameter	Drg. No.	548.12 M/c 548 ✓	→ Step length 31 M/c
7	Width of Pellet Die	Drg. No.	195 M/c ✓	Undercut = 2.8 M/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 M/c 32 x 7 x 9.1 M/c	(4 x 8) M/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	Face side Step 3 mm Deep Bolt Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619 M/c ✓	Tapping No.
13	Tapping Hole Diameter		M16. Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 M/c	Tapping Depth 31.5
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 M/c	All Rows					Rev 212
3	External Relief Depth		36 M/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		29	10	24			

Inspected By (Sign) & Date

Ravi 29/10/24

Reviewed by (Engineer-CNC)

Manager-QA