



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.		13186	33/43/66
2	Machined By		V.T.L. H/c Shop	Dry Hole 1-2-0-320
3	Pallet Die No.		13626 (6.0) H/c	Row 208
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c Step 00- 893 H/c	Step length 31 H/c
6	Inside Diameter	Drg. No.	548.12 H/c (Boss = 548.1)	Tapper 2°
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 53 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c 32 x 7 x 9.1 H/c	(4 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Row Side Step
10	Drilling Area Surface Smoothness		OK	2 H/c Deep
11	Tapping Operator		H/c Shop	Back Side
12	Tapping PCD		619 H/c	Tapping No. of Holes - 2
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 33.6 H/c	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/11/24

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	6.5 H/c 7.0 H/c	6.5 H/c	All Rows = 33 H/c				Row = 12
3	External Relief Depth	—	7.0 H/c	All Rows = 33 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		9	"	24			

Inspected By (Sign) & Date

Ravi 31/11/24

Reviewed by (Engineer-CNC)

Manager-QA