



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.		13397	53/58 ✓
2	Machined By		V. T. L. M/c Shop	Drg. No. 1.2.0.810
3	Pallet Die No.		12806 (B.8) M/c	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	746 M/c	Step 002 749 M/c
6	Inside Diameter	Drg. No.	630.12 M/c	Tap hole 4"
7	Width of Pellet Die	Drg. No.	255 M/c	Step length 27.5
8	Grooves as per Drawing	Drg. No.	22x8x7 M/c 22x8x7 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping W. of holes - 12 Botm Side
12	Tapping PCD		685 M/c	
13	Tapping Hole Diameter		M22 - Check by M22 B.1	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 28.3 M/c	Tapping Depth 28.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/11/24	
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. 60° Rep. 36
2	External Relief Dia	4.3 M/c	outside (3-3)	Inner
3	External Relief Depth		12 M/c	5 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		28	11
Inspected By (Sign) & Date			Ravi 28/11/24	

Reviewed by (Engineer-CNC)

Manager-QA