



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.		13499 ✓	25/60/90
2	Machined By		V. T. C. n/c Shop	Drg. No. 1.3.9.559
3	Pallet Die No.		12959 (6.0) n/c	Rev: 03 ✓
4	Die Category	Drg. No.	M720	
5	Out Side Diameter	Drg. No.	7.52 n/c	Step 002 7.77 n/c / 7.76 n/c / 6.75 n/c ✓
6	Inside Diameter	Drg. No.	5.72.12 n/c ✓	Step length 4.3 n/c
7	Width of Pellet Die	Drg. No.	2.70 n/c ✓	24.5 n/c
8	Grooves as per Drawing	Drg. No.	1.06 x 8 x 12 n/c / 8.8 x 8 x 12 n/c	Order cuts 12.5 n/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 6
12	Tapping PCD		660 n/c ✓	
13	Tapping Hole Diameter		0.31" ± Check by 0.31" Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 1st side One side	
15	Tapping Hole Depth		Drill Depth 35 n/c Tapping Depth 33 n/c ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 14/12/24	1 Slot 39.1 n/c width de n/c Deep
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° Row 2 7
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Rows = 55 n/c ✓	
3	External Relief Depth		7.0 n/c All Rows = 30 n/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		14 12 24	
Inspected By (Sign) & Date			Ravi 14/12/24	

Reviewed by (Engineer-CNC) *Satya 14/12/24*

Manager-QA