



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.		13238 ✓	60/65.5 ✓
2	Machined By		V.T.L n/c Shop	Dy N.: 18.9.909
3	Pallet Die No.		14074 (12.0) n/c ✓	Rev: 03 ✓
4	Die Category	Drg. No.	S33TD	
5	Out Side Diameter	Drg. No.	639.7 n/c ✓ Step 00. 652.3 n/c ✓	Tapet = 3"
6	Inside Diameter	Drg. No.	508.8 n/c ✓ / (10 Step - 539.7 / 599.3 n/c) ✓	Step length = 32
7	Width of Pellet Die	Drg. No.	175 n/c ✓	
8	Grooves as per Drawing	Drg. No.	3042147.25 n/c / 9425 n/c ✓	[Core Side]
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	[Step = 0.5 n/c]
10	Drilling Area Surface Smoothness		ok ✓	[Reap]
11	Tapping Operator		n/c Shop	[Tapping No]
12	Tapping PCD		574 n/c ✓	[of holes = 4]
13	Tapping Hole Diameter		M16 = Check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and Third side 4 slot ✓	
15	Tapping Hole Depth		Drill Depth = 30.3 n/c ✓ Tapping Depth = 28.5 n/c ✓	
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		ok ✓	

Inspected By (Sign) & Date

Ravi 14/2/24

1	As per programme no.		_____	[4 slot]
2	Gun Drilling Work Completed On		_____	51.5 n/c long
3	Hole Finish In Gun Drilling	Marked	ok ✓	28.1 n/c width
4	Defective Holes (If Any)		No	15 n/c Reap

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60°

1	Counter Sinking Depth & Finish	ok ✓							Row = 5
2	External Relief Dia	12.5 n/c ✓	All Rows						
3	External Relief Depth	✓	5.5 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 14/2/24						

Satyam
14/2/24
Reviewed by (Engineer-CNC)

Manager-QA