



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.			
2	Machined By		13494	33/33/66
3	Pallet Die No.		V.T.L. n/c Shop	Qty 100, 1.8.0-609
4	Die Category	Drg. No.	13928(6.0) n/c	Rev 103
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	680.7 n/c / Step 00. 693 n/c	Tappet = 2"
7	Width of Pellet Die	Drg. No.	546.12 n/c / (Box = 548.4)	Step length = 3.1 n/c
8	Grooves as per Drawing	Drg. No.	195 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 n/c / 32 x 7 x 9.2 n/c	(4 x 8) n/c
10	Drilling Area Surface Smoothness		ok	[Face Side Step] [2 n/c Each] [Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		619 n/c	[Tapping Hole] [of holes = 2] [Both Side]
14	Tapping On Second Side	Half pitch of 1st side	N/C, Check by N/C Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth, 33.4 n/c	Tapping Depth, 31.6
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 11/12/24

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

Counter 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 n/c / 1.0 n/c	6.5 n/c	All Rows = 38 n/c					Row = 12
3	External Relief Depth		1.0 n/c	All Rows = 38 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			11	12	24			

Inspected By (Sign) & Date

Ravi 11/12/24

Satish 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA