



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		13416 ✓	36/51/66 ✓
3	Pallet Die No.		V.T.L H/C Shop	Qty No. 12.0 = 809
4	Die Category	Drg. No.	13794 (B.O) H/C	Rev. 03 ✓
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	680.7 H/C, Step 001 = 693 H/C, Tapper = 8	
7	Width of Pellet Die	Drg. No.	546.12 H/C (Row 2 = 548.3 H/C, Step length = 31 H/C, 31.3 H/C)	
8	Grooves as per Drawing	Drg. No.	195 H/C ✓	Under cut = 2.5 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.2 H/C 32.7 x 9.2 H/C (4 x 8) H/C	
10	Drilling Area Surface Smoothness		ok	[Face Side Step 2 H/C Ramp Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		619 H/C ✓	[Tapping H/C of holes = 2]
14	Tapping On Second Side	Half pitch of 1st side	H16 = Check by H16 Bolt ok	[Both Side]
15	Tapping Hole Depth		Drill Depth = 33.4 H/C	Tapping Depth = 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		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 H/C 7.0 H/C	6.5 H/C	All Rows = 30 H/C ✓					Row = 12
3	External Relief Depth		7.0 H/C	All Rows = 15 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			11	12	24			

Inspected By (Sign) & Date

Ravi 11/12/24

Reviewed by (Engineer-CNC)

Manager-QA