



# 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.		13260	30/66
2	Machined By		V.T.L H/C Shop	Dry No. 1.2.22 330
3	Pallet Die No.		13788 (G.C) H/C	Rev 208
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/C Step 001 693 H/C	Taper 8°
6	Inside Diameter	Drg. No.	546.12 H/C (Bore 548.1 H/C)	Step length 31 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	31.3 H/C
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/C   32.7 x 9.1 H/C (4 x 8) H/C	Undercut 2.8 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 H/C Deep Body Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 H/C	Tapping No. of H-Pes. 2 Both Side
13	Tapping Hole Diameter		N/C - Check by H/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.3 H/C	Tapping Depth 31.8 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 23/12/24

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

1	Counter Sinking Depth & Finish	ok						Counter 30°
2	External Relief Dia	7.0 H/C	All Pcs					Rev 12
3	External Relief Depth		36 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		23	12	24			

### Inspected By (Sign) & Date

Ravi 23/12/24

Reviewed by (Engineer-CNC)  
23/12/24

Manager-QA