



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.		13870	22/66
2	Machined By		V.T.L H/c Shop	Drg No. (3.0) = 3.0
3	Pallet Die No.		14005 (3.0) H/c	Rev = 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c Step OD = 693 H/c	Tappet = 3
6	Inside Diameter	Drg. No.	546.12 H/c (Bot = 548.34)	Step length = 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Load cut = 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c 32 x 7 x 9.1 H/c (4 x 8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Face side step]
11	Tapping Operator		H/c Shop	[2 H/c Deep Back side]
12	Tapping PCD		619 H/c	[Tapping No. of Holes = 2]
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	[Back side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.3 H/c	Tapping Depth = 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/1/25

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

Counters 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	9.0 H/c	All Rows							
3	External Relief Depth		44 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		15	1	25					

Inspected By (Sign) & Date

Ravi 15/1/25

15/1/25

Reviewed by (Engineer-CNC)

Manager-QA