



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		13795	37/66
3	Pallet Die No.		V.T.L. N/C Shop	Dyler 129 = 32
4	Die Category	Drg. No.	14003 (6.0) H/H	Rev = 08
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.1 H/H	Step 002 693 H/H Tapper 3
7	Width of Pellet Die	Drg. No.	546.12 H/H (Box = 548.1 H/H)	Step length 2.1 H/H
8	Grooves as per Drawing	Drg. No.	195 H/H	Undercut 2.8 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 H/H 32 x 7 x 9.1 H/H	(4 x 8) H/H
10	Drilling Area Surface Smoothness		OK	Face side step 2 H/H Deep Bottom Side
11	Tapping Operator		OK	
12	Tapping PCD		N/C Shop	
13	Tapping Hole Diameter		619 H/H	Tapping No of holes 2 Both Side
14	Tapping On Second Side	Half pitch of 1st side	N/C Check by N16 Bolt	
15	Tapping Hole Depth		OK	Tapping Depth 3.6
16	Perpendicularity of Tapped Hole		Drill Depth = 33.2 H/H	
17	Visual Inspection Before Gun Drilling		Yes OK	

Inspected By (Sign) & Date

Ravi 17/1/25

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

1	Counter Sinking Depth & Finish	OK					Counter = 60°
2	External Relief Dia	1.0 H/H	All Rows				Row = 12
3	External Relief Depth		29 H/H				
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		17	1	25		

Inspected By (Sign) & Date

Ravi 17/1/25

Reviewed by (Engineer-CNC)

Manager-QA