



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.		14017	57/66
2	Machined By		V.T.L M/c SHob	Dy. No. 13.02.930
3	Pallet Die No.		14013 (10.0) H/H	Row 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/H	Step 00, 693 H/H
6	Inside Diameter	Drg. No.	548.12 H/H	(Bar = 548.1 H/H) Step length 3 H/H
7	Width of Pellet Die	Drg. No.	195 H/H	Under cut 2.8 H/H
8	Grooves as per Drawing	Drg. No.	32x7x9.1 H/H	32x7x9.1 H/H (4x8) H/H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c SHob	Face side Step
12	Tapping PCD		619 H/H	2 H/H Deep Both Side
13	Tapping Hole Diameter		HIG > Check by HIG Bolt	Tapping depth of Holes & Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 H/H	Tapping Depth = 31.6 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/1/25

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							Count on 60
2	External Relief Dia	11.0 H/H	All Rows						Row 8
3	External Relief Depth		9 H/H						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Forging						
6	Material Sent For Hardening On Date		28	1	25				

Inspected By (Sign) & Date

Ravi 28/1/25

Reviewed by (Engineer-CNC)

Manager-QA