

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		14098 ✓	23/66 ✓
3	Pallet Die No.		N.T.L. H/C Shop	Drg No. 13.0.330
4	Die Category	Drg. No.	14034(2.0) H/C ✓	Rev. 08 ✓
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	680.1 H/C, Step 0.5, 692.7 H/C	Tapping 3"
7	Width of Pellet Die	Drg. No.	546.12 H/C (Bore = 548.1 H/C)	Step length = 31 H/C
8	Grooves as per Drawing	Drg. No.	195 H/C	Under cut = 2.8 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 H/C 32 x 7 x 9.1 H/C	Face Side Step 2 H/C Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 2 Both Side
12	Tapping PCD		619 H/C ✓	
13	Tapping Hole Diameter		H/C = Check by H/C Bolt	Tapping Depth = 31.7 H/C
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 15/2/25	
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 = 20 Low 10
2	External Relief Dia	9.0 H/C	All Rows	
3	External Relief Depth		38 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 / 2 / 25	
Inspected By (Sign) & Date			Ravi 15/2/25	

Reviewed by (Engineer-CNC)

Manager-QA