

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9439

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

Check Parameter	Specification	Observations	Remarks
1 Work Order No.		14411	40/50/70
2 Machined By		N. T. L. H/C Shop	Dr. H. 6.8.9-372
3 Pallet Die No.		14336 (810) H/C	Rev 203
4 Die Category	Drg. No.	H. Jumbo	
5 Out Side Diameter	Drg. No.	688 H/C Step on = 697.7 H/C Tappet	5
6 Inside Diameter	Drg. No.	546.12 H/C (Box = 548.3 H/C)	Step length = 98.5
7 Width of Pellet Die	Drg. No.	915 H/C	Under cut = 2 H/C
8 Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.1 H/C / 29.5 x 10 x 9.1 H/C (6 x 8) H/C	
9 Fitting Sizes on CNC Plate	Drg. No.	OK	Face side Step
10 Drilling Area Surface Smoothness		OK	2 H/C Deep Bottom
11 Tapping Operator		H/C Shop	Side
12 Tapping PCD		618 H/C	Tapping H/C
13 Tapping Hole Diameter		H/C Check by H/C Bolt	of Holes 2
14 Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15 Tapping Hole Depth		Drill Depth = 32.3 H/C	Tapping Depth = 30.5
16 Perpendicularity of Tapped Hole		Yes	
17 Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date		Rawi 22/3/25	
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
2 External Relief Dia	8.5 H/C / 9.0 H/C	8.5 H/C All Rows = 30 H/C	Row 2 12
3 External Relief Depth		9.0 H/C All Rows = 20 H/C	
4 Inspection Done Before Hardening By (Name)		Rawi	
5 Material Sent For Hardening By (Name)		Lark Porrace	
6 Material Sent For Hardening On Date		22 3 25	
Inspected By (Sign) & Date		Rawi 22/3/25	

Reviewed by (Engineer-CNC)

Manager-QA