



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.		10113 to 10187 to 10237	30/5/11
2	Machined By		V.T.L. n/a Shop	Drg No. L.S.O. 609
3	Pallet Die No.		10757 (G.O) n/a	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/a Step 00, 692.8 n/a	Step length, 31 n/a
6	Inside Diameter	Drg. No.	548.12 n/a	Tapper, 3°
7	Width of Pellet Die	Drg. No.	195 n/a	Under cut = 2.5 n/a
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/a / 32 x 7 x 8 n/a (4 x 8) n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step and Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		619 n/a	Tapping No. 4
13	Tapping Hole Diameter		M16.2 Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 n/a Tapping Depth = 31.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/9/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		n/a

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 30°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 n/a / 7.0 n/a	6.5 n/a All Lines	7.0 n/a All Lines					
3	External Relief Depth		16 n/a	16 n/a					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		2	9	23				

Inspected By (Sign) & Date

Ravi 21/9/23

Reviewed by (Engineer-CNC)

Manager-QA