

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14653	35/63/78
2	Machined By		V.T.L. H/c Shop	Dy. H. 13.0.39C
3	Pallet Die No.		14213 (G.O) H/c	Rev 232
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 H/c / 232 Step OD = 630.4 H/c	1.543 H/c
6	Inside Diameter	Drg. No.	480.12 / 489.12 H/c	500.12 H/c
7	Width of Pellet Die	Drg. No.	182 H/c	Step length 28 H/c
8	Grooves as per Drawing	Drg. No.	37.12 x 8 x 9.5 H/c	27.12 x 8 x 9.5
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 4
12	Tapping PCD		540 H/c	
13	Tapping Hole Diameter		MIG - Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 1st side	2nd side
15	Tapping Hole Depth		Drill Depth 28.4 H/c	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Raw: 13/4/25	19164
1	As per programme no.			28.1 H/c width
2	Gun Drilling Work Completed On			17 H/c Deep
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		Row 10
2	External Relief Dia	6.5 H/c / 7.0 H/c	6.5 H/c All Rows = 43 H/c	
3	External Relief Depth		7.0 H/c All Rows = 15 H/c	
4	Inspection Done Before Hardening By (Name)		Raw:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		13	4
Inspected By (Sign) & Date			Raw: 13/4/25	

Reviewed by (Engineer-CNC)

Manager-QA