



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.		10512	30/40/79 ✓
2	Machined By		V.T.L. H/c Shop	Qty No. 1-30, 717
3	Pallet Die No.		11176 (G.O) ✓	Reos of ✓
4	Die Category	Drg. No.	M.S. Jumbo	
5	Out Side Diameter	Drg. No.	1008 ✓ Step OD, 1023 ✓	Tapper 2-8°
6	Inside Diameter	Drg. No.	850.12 ✓ / 850.14 ✓	Step length ✓
7	Width of Pellet Die	Drg. No.	266 ✓	Under cut 2.24 ✓
8	Grooves as per Drawing	Drg. No.	45x8x10 ✓ 45x8x10 ✓	Face Side Step ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Deep Both Side ✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 2
12	Tapping PCD		935 ✓	Both Side ✓
13	Tapping Hole Diameter		M2-2 Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 49.3 ✓ Tapping Depth 99.8 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raoi 6/11/23

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

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

Counter = 30°

1	Counter Sinking Depth & Finish	ok							Low 2 16
2	External Relief Dia	6.5 ✓ 7.3 ✓	6.5 ✓ All Lines	7.3 ✓ All Lines					
3	External Relief Depth		49 ✓	39 ✓					
4	Inspection Done Before Hardening By (Name)		Raoi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		6	11	23				

Inspected By (Sign) & Date

Raoi 6/11/23

Reviewed by (Engineer-CNC)

Manager-QA