



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.		10417 ✓	33/68 ✓
2	Machined By		V.T.C. H/c Shop	Dry Hole 1 & 2 609
3	Pallet Die No.		11190 (G.O) H/H ✓	Rev 2.01 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/H ✓	Step OD = 698.8 H/H ✓
6	Inside Diameter	Drg. No.	548.12 H/H ✓	Step length = 31 H/H ✓
7	Width of Pellet Die	Drg. No.	195 H/H ✓	Under cut = 2.5 H/H ✓
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/H ✓	32 x 7 x 8 H/H ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	face side step 2 H/H ✓
10	Drilling Area Surface Smoothness		ok	Back Both side
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		619 H/H ✓	4 holes, 4
13	Tapping Hole Diameter		H16. Check by H16 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 H/H ✓	Tapping Depth = 31.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/11/23

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

Counters 30°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	7.5 H/H ✓	7.5 5 H/H All lines							
3	External Relief Depth		33 H/H ✓							
4	Inspection Done Before Hardening By (Name)		Ravi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		11	11	23					

Inspected By (Sign) & Date

Ravi 11/11/23

Reviewed by (Engineer-CNC)

Manager-QA