



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.		10639	85/63/78
2	Machined By		V.T.L. H/C Shop	Drg No. 1-80-2-390
3	Pallet Die No.		10902 (6.0) H/C	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 H/C 632 H/C Step 002	530.5 H/C 543 H/C
6	Inside Diameter	Drg. No.	480.1 H/C 489.1 H/C 500.1 H/C	Step length 26 H/C 16.5 H/C
7	Width of Pellet Die	Drg. No.	182 H/C	
8	Grooves as per Drawing	Drg. No.	27x12x8x9.5 H/C 37x12x8x9.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of Holes: 4
12	Tapping PCD		540 H/C	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and	Third Side One Slot
15	Tapping Hole Depth		Drill Depth: 28.3 H/C	Tapping Depth: 28.5 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date		Ravi 15/11/23		1 Slot	
1	As per programme no.			28.1 mm width	
2	Gun Drilling Work Completed On			17 mm 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							Ravi 10
2	External Relief Dia	6.5 H/C 7.0 H/C	6.5 H/C All Lines	7.0 H/C All Lines					
3	External Relief Depth		43 H/C	15 H/C					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Fornace						
6	Material Sent For Hardening On Date		15	11	23				
Inspected By (Sign) & Date		Ravi 15/11/23							

Reviewed by (Engineer-CNC)
 15/11/23

Manager-QA