



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.		10449	20/30/100
2	Machined By		V.T.C. H/c Shop	Digital I.C.C. 9343
3	Pallet Die No.		11531 (G.O) H/c	Rev = 03
4	Die Category	Drg. No.	S. Jumbo	Tapping
5	Out Side Diameter	Drg. No.	1051 H/c Step 002 1041.84 H/c	Tapping 4°
6	Inside Diameter	Drg. No.	851.14 H/c / 851.2 H/c	Tapping 13° / Step length 32.5
7	Width of Pellet Die	Drg. No.	251 H/c	
8	Grooves as per Drawing	Drg. No.	50x11x10.2 H/c / 50x11x10.2 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 24 Both Side
12	Tapping PCD		958 H/c	
13	Tapping Hole Diameter		M302, Check by M30 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 48.5 H/c	Tapping Depth 49.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/1/24

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

1	Counter Sinking Depth & Finish	OK					Counter = 60
2	External Relief Dia	6.5 H/c / 7.5 H/c	6.5 H/c All Lines	7.5 H/c All Rows			
3	External Relief Depth		80 H/c	70 H/c			
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	1	24		

Inspected By (Sign) & Date Ravi 11/1/24

Reviewed by (Engineer-CNC)

Manager-QA