



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.		11143	18/03/06
2	Machined By		V.T.L. H/c Shop	Drugs: 13.02.09
3	Pallet Die No.		11486 (B.0) H/c	Rep 201
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/c	Step 00, 689.5 H/c Tapper = 8
6	Inside Diameter	Drg. No.	548.14 H/c	Step length = 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Undercut = 8.4 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c 32 x 7 x 8 H/c	Face side step 3 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Both side
10	Drilling Area Surface Smoothness		ok	Deep Both side
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		619 H/c	of 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/c	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/1/24

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

Counters 30°

1	Counter Sinking Depth & Finish	ok								Rep = 12
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c	All Rows	7.0 H/c	All Rows				
3	External Relief Depth		48 H/c		43 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		25	1	24					

Inspected By (Sign) & Date

Ravi 25/1/24

Reviewed by (Engineer-CNC)
25/1/24

Manager-QA