



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11219	30/55/75
2	Machined By		V. T. L. H/c Shop	Dy. No. 13.0. 334
3	Pallet Die No.		10438 (6.0) H/c	Rev. No.
4	Die Category	Drg. No.	M490	
5	Out Side Diameter	Drg. No.	722 H/c / 734 H/c Step 002	777 H/c / 786 H/c / 675 H/c
6	Inside Diameter	Drg. No.	572.14 H/c	Step length = 42 H/c
7	Width of Pellet Die	Drg. No.	270 H/c	24.5 ²¹ 24.5
8	Grooves as per Drawing	Drg. No.	88 x 8 x 12 H/c / 106 x 8 x 12 H/c	Under cut = 27.5 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: 6
12	Tapping PCD		660 H/c	
13	Tapping Hole Diameter		Ø 3/4" - Check by Ø 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and	Other Side One Slot
15	Tapping Hole Depth		Drill Depth = 36.5 H/c	Tapping Depth = 38.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/24

1	As per programme no.			1 Slot 39.1 H/c width 26 H/c Deep
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 / 7.0 H/c	6.5 H/c All Rows	7.0 H/c All Rows				Row = 7
3	External Relief Depth		45 H/c	20 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		3	2	24			

Inspected By (Sign) & Date

Ravi 31/7/24

Reviewed by (Engineer-CNC)

Manager-QA