



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.			
2	Machined By		11165	33/38/66
3	Pallet Die No.		V-T-L n/c Shop	Qty No. 1-8. D. 609
4	Die Category	Drg. No.	11482 (G.O) n/c	Rev. 01
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.69 n/c Step 00 = 692.8 n/c	Tapkes = 2"
7	Width of Pellet Die	Drg. No.	548.12 n/c	Step length = 3" n/c
8	Grooves as per Drawing	Drg. No.	195 n/c	Undercut = 2.4 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8 n/c (4 x 8) n/c	
10	Drilling Area Surface Smoothness		ok	FP Face Side Step 2 n/c
11	Tapping Operator		n/c Shop	CRack Both Side
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		NIG = Check by NIG Bolt	Tapping No. 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 n/c	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/8/24

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

Counter Sinking Depth & Finish	ok					Counter = 30
External Relief Dia	6.5 n/c 7.5 n/c	6.5 n/c All Rows	7.5 n/c All Rows			Rep = 12
External Relief Depth	/	33 n/c	98 n/c			
Inspection Done Before Hardening By (Name)		Ravi				
Material Sent For Hardening By (Name)		Lark Purchase				
Material Sent For Hardening On Date		6	2	24		

Inspected By (Sign) & Date

Ravi 6/8/24

Checked by (Engineer-CNC)

Manager-QA