



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

6946

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10989	55/66
3	Pallet Die No.		V.T.L. H/c Shop 11769 (3.5) H/c	Dy. No. 1.2.02.9136 Recor. of
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032.2 H/c	
6	Inside Diameter	Drg. No.	Step 002 1033 H/c	Tappers 3°
7	Width of Pellet Die	Drg. No.	900.12 H/c / 900.14 H/c	Step length = 3.7 H/c ⓐ 30.2 H/c
8	Grooves as per Drawing	Drg. No.	375 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 8 x 13 H/c / 29.4 x 8 x 13 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping no. of holes = 15 Both Side
13	Tapping Hole Diameter		970 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H24 - Check by H24 Bolt ok	
15	Tapping Hole Depth		Drill Depth = 39 H/c	Tapping Depth = 36.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/8/24

1	As per programme no.			2 Slot ⓐ 32.1 H/c width 7.5 H/c Depth Both Side
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 = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 H/c	outside (4-4)	Inner					
3	External Relief Depth		18 H/c	11 H/c					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Romare						
6	Material Sent For Hardening On Date		10	2	24				

Inspected By (Sign) & Date

Ravi 10/8/24

Satya 10/2/24

Reviewed by (Engineer-CNC)

Manager-QA