



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.		10929 ✓	55/66
2	Machined By		V.T.L.H/a Shop	Dry No. 6.8.09/136
3	Pallet Die No.		11770 (3.5) H/H	Revised
4	Die Category	Drg. No.	S. Jumbo ✓	
5	Out Side Diameter	Drg. No.	1032.2 H/H ✓ Step 00, 1033 H/H ✓	Tap No. 3"
6	Inside Diameter	Drg. No.	900.12 H/H ✓	Step length 33 H/H
7	Width of Pellet Die	Drg. No.	37.5 H/H ✓	33 H/H
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 H/H ✓ 29.5 x 8 x 13 H/H ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/a Shop	Tapping No. of H-Tee: 15 Both Side
12	Tapping PCD		970 H/H	
13	Tapping Hole Diameter		M24 = Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 38.5 H/H	Tapping Depth = 35.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/8/24

1	As per programme no.		_____	Slit 38.1 H/H width 7.5 H/H Depth Both Side
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 1 Hole Closed	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Countdown: 60°
Kao = 59

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.0 H/H	20 Side (4-4)	Inner				
3	External Relief Depth	✓	18 H/H ✓	11 H/H ✓				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		14	2	24			

Inspected By (Sign) & Date

Ravi 14/8/24

Reviewed by (Engineer-CNC)

Manager-QA