



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.C. n/c Shop	Drill No. L.E.C. 9136
3	Pallet Die No.		11772 (3-5) n/c	Rev. 201
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032 n/c, Step 002 1033 n/c	Tapper 3°
6	Inside Diameter	Drg. No.	900.12 n/c / 900.2 n/c	Step length 37 n/c
7	Width of Pellet Die	Drg. No.	374.5 n/c	Under cut = 0.5 n/c
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 n/c / 29.3 x 8 x 13 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes: 15 Both Side
12	Tapping PCD		970 n/c	
13	Tapping Hole Diameter		n/c - Check by n/c 4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.7 n/c	Tapping Depth 38 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 23/7/24	2 slot
1	As per programme no.		_____	39.1 n/c width 7.5 n/c Deep 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				
1	Counter Sinking Depth & Finish	ok		Counter 2 60 Row 59
2	External Relief Dia	4.0 n/c	outside (4-4)	Inner
3	External Relief Depth		18 n/c	11 n/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		23	24
Inspected By (Sign) & Date			Ravi 23/7/24	

Reviewed by (Engineer-CNC)

Manager-QA