



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.		11452	41/51 40/50
2	Machined By		V.T.L. H/C Shop	Dy. No. L. & Co. 10295
3	Pallet Die No.		11419 (B.O) H/C	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	682 H/C	Step 602 Tapper 12° Step length 32 H/C
6	Inside Diameter	Drg. No.	580.12 H/C	
7	Width of Pellet Die	Drg. No.	266 H/C	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 H/C	28.5 x 6 x 12 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 = 12 Both Side
12	Tapping PCD		630 H/C	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 25.8 H/C	Tapping Depth = 23.8 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/3/24

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

Counters 60°

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	3.5 H/C	outside (3-3)		Inner			
3	External Relief Depth		16 H/C		10 H/C			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Porrace			
6	Material Sent For Hardening On Date		13	3	24			

Inspected By (Sign) & Date

Ravi 13/3/24

Sat 13/3/24

Reviewed by (Engineer-CNC)

Manager-QA