



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.		11324 to 11410	33/53/60
2	Machined By		V.T.C n/c Shop	Dry Hole 12.0-6.9
3	Pallet Die No.		11928 (G.O) n/c	Recess
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step 602.693 n/c	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8 n/c	(4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side step & n/c Deep Blue ink
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping n/c of Hole 4 Body side
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 34 n/c Tapping Depth 31.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/3/24

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

1	Counter Sinking Depth & Finish	OK					Counter 30°
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c	All Rows	7.0 n/c	All Rows	Row 2 12
3	External Relief Depth			33 n/c		13 n/c	
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Porrage			
6	Material Sent For Hardening On Date		18	3	24		

Inspected By (Sign) & Date

Ravi 18/3/24

Reviewed by (Engineer-CNC)

Manager-QA