



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.		11448 11324 to 4296	40/66
2	Machined By		V.T.C. H/c Shop	Drg. No. (L.S.D.) 209
3	Pallet Die No.		11924 (8.0) H/c	Rev. cl
4	Die Category	Drg. No.	M. Jumbo 800 ^{24x3}	
5	Out Side Diameter	Drg. No.	680.7 H/c / Step 0.6 692.8 H/c	Tapping 89
6	Inside Diameter	Drg. No.	548.12 H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.4 H/c
8	Grooves as per Drawing	Drg. No.	32x7x8 H/c 32x7x8 H/c (4x8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side Step 2 H/c
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		H/c Shop	Tapping No. of Holes - 4
12	Tapping PCD		619 H/c	Both Side
13	Tapping Hole Diameter		MIG 2 Check by MIG Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 33.5 H/c	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 14/3/24

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 Counter 309

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	9.0 H/c	All Rows							
3	External Relief Depth		26 H/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		14	3	24					

Inspected By (Sign) & Date Ravi 14/3/24

Reviewed by (Engineer-CNC)

Manager-QA