



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.		11324	40/60/66
2	Machined By		V.T.L. H/c Shop	Dypl. U.S. 03609
3	Pallet Die No.		11987 (G.O) H/c	Row 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c Step OD, 693 H/c	Tappers 8°
6	Inside Diameter	Drg. No.	548.14 H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c 32 x 7 x 8 H/c (4 x 8)	Fore Side Step 2 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Deep Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 4
12	Tapping PCD		619 H/c	Both Side
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 33.5 H/c	Tapping Depth 3.2
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 = 30

1	Counter Sinking Depth & Finish	OK							Row 12
2	External Relief Dia	6.5 H/c / 7.0 H/c	6.5 H/c All Rows	7.0 H/c All Rows					
3	External Relief Depth	/	26 H/c	6 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