



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

5609

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.		9640	28/38/66
2	Machined By		V.T.L. H/c Shop	Dr No. 18.0.609
3	Pallet Die No.		10248 (6.0) H/c	Rev 201
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/c	Step length = 8"
6	Inside Diameter	Drg. No.	548.12 H/c	Step length = 31"
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.5"
8	Grooves as per Drawing	Drg. No.	32x7x8 H/c	(4x8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step 2"
10	Drilling Area Surface Smoothness		OK	Deep Back Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	Tapping No of Holes = 4 Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 33.4 H/c	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rev: 6/6/23

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 H/c / 7.3 H/c	6.5 H/c All Lines	7.3 H/c All Lines		Rev = 12
3	External Relief Depth		28 H/c	28 H/c		
4	Inspection Done Before Hardening By (Name)					
5	Material Sent For Hardening By (Name)					
6	Material Sent For Hardening On Date		6	6	23	

Inspected By (Sign) & Date

Rev: 6/6/23

Reviewed by (Engineer-CNC)

Manager-QA