



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.		9644 to 9957	25/35/66
2	Machined By		V.T.L. n/c Shop	Dy No. LS.02609
3	Pallet Die No.		10589 (B.O.) n/c	Rev 201
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step 00, 699 n/c	Tappers 8°
6	Inside Diameter	Drg. No.	548.14 n/c	Step length 4.31 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+7+8 n/c 32+7+8 n/c (4+8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping No
13	Tapping Hole Diameter		N/C: Check by N/C Bolt	of Hole 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/7/23

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 20°
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Lines	7.0 n/c All Lines			Rep 2 14
3	External Relief Depth		41 n/c	31 n/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		17	7	23		

Inspected By (Sign) & Date

Ravi 17/7/23

Reviewed by (Engineer-CNC)

Manager-QA