



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.		11494	35/50
2	Machined By		V.T.L. n/c Shop	Dr. No. 13.0 932
3	Pallet Die No.		11938 (2.8) n/c	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 n/c Step OD = 801 n/c	Tapper 9.5
6	Inside Diameter	Drg. No.	660.12 n/c	Step length 28.1 n/c
7	Width of Pellet Die	Drg. No.	316 n/c	Under cut = 20.5 n/c
8	Grooves as per Drawing	Drg. No.	18x9x6 n/c 18x9x6 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H. of Holes = 12 Both Side
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22.8 n/c	Tapping Depth = 20.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 31/4/24	
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 - 4 Hole Calves ok	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		ok	Counter = 60° Rev = 59°
2	External Relief Dia		3.3 n/c	Outer Side (3-3) Inner 15 n/c
3	External Relief Depth		20 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		3	4 24
Inspected By (Sign) & Date			Ravi 31/4/24	

Reviewed by (Engineer-CNC)
Satsa 31/4/24

Manager-QA