



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.		11969	
2	Machined By		M.T.C. n/c Shop	33/66
3	Pallet Die No.		12251 (B.O) n/c	Drill No. 1.8.2009
4	Die Category	Drg. No.	M. Jumbo	Renod
5	Out Side Diameter	Drg. No.	68.7 n/c Step 00, 393 n/c	Tabber 3°
6	Inside Diameter	Drg. No.	54.12 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Undercut - 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32.7 x 8 n/c 32.7 x 8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	Deep hole side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping n/c
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of holes 4
14	Tapping On Second Side	Half pitch of 1st side	ok	Back 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 14/5/24*

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

1	Counter Sinking Depth & Finish	ok							Counter 300
2	External Relief Dia	7.5 n/c	7.5 n/c	All Ribs					
3	External Relief Depth			33 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		14	5	24				

Inspected By (Sign) & Date *Ravi 14/5/24*

Satyam
14/5/24
Reviewed by (Engineer-CNC)

Manager-QA