



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.		11916	47/70
2	Machined By		V. T. L. n/c Shop	Dy. No. 13.02.317
3	Pallet Die No.		10744 (8.0) n/c	Rev. 03
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	688 n/c, Step 00, 692 n/c	Tabber 5
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 23.5
7	Width of Pellet Die	Drg. No.	215 n/c	Under cut 1.3 n/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 n/c 29.5 x 10 x 8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	Deep Botu Side
11	Tapping Operator		n/c Shop	Tapping n/c of holes 2 Botu Side
12	Tapping PCD		618 n/c	
13	Tapping Hole Diameter		N16 Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32.7 n/c	Tapping Depth 30
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Lavi 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 30
2	External Relief Dia	9.0 n/c	All Rows					Row 2 12
3	External Relief Depth		23 n/c					
4	Inspection Done Before Hardening By (Name)		Lavi					
5	Material Sent For Hardening By (Name)		Lark Porrace					
6	Material Sent For Hardening On Date		14	5	24			

Inspected By (Sign) & Date

Lavi 14/5/24

Reviewed by (Engineer-CNC)

Manager-QA