



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.		12061	23/66
2	Machined By		V.T.L. H/c Shop	25/66
3	Pallet Die No.		12486 (G.O) H/c	Dry H/c 1.2.0. 220
4	Die Category	Drg. No.	N. Jumbo	Rev. 05
5	Out Side Diameter	Drg. No.	680.2 H/c, Shop OD = 693 H/c	Tapping 3
6	Inside Diameter	Drg. No.	548.12 H/c	Shop length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Width cut 2.75 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c 32 x 7 x 8 mm (4 x 3)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Shop
10	Drilling Area Surface Smoothness		OK	2 H/c Deep H/c
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		619 H/c	of Hole 4
13	Tapping Hole Diameter		H16 = Check by H16 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.5 H/c	Tapping Depth 31.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 26/6/24

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	7.0 H/c	1st Pad	2nd Pad			Ravi 12
3	External Relief Depth		43 H/c	41 H/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		26	6	24		

Inspected By (Sign) & Date

Ravi 26/6/24

Sut 26/6/24

Reviewed by (Engineer-CNC)

Manager-QA