



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7846

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.		12409	22/40
2	Machined By		V.T.L. H/C Shop	Dry H., 12.0 21
3	Pallet Die No.		11848(2.8) H/C	Rev 2.01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C, Step OD, 499 H/C	Tapper - 12"
6	Inside Diameter	Drg. No.	420.12 H/C	Step length, 17 H/C
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes: 8 Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		0.814" - Check by 0.814" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 18.3 H/C	Tapping Depth, 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/7/24

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, 60° Low - 20
2	External Relief Dia	3.3 H/C	Outside (2.2)	Inner			
3	External Relief Depth		20 H/C	18 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		17	7	24		

Inspected By (Sign) & Date

Ravi 17/7/24

Reviewed by (Engineer-CNC)

Manager-QA