



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.			
2	Machined By		12585	45/60
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 1298 III
4	Die Category	Drg. No.	12998 (H.c) H/c	Low
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	780 H/c Shop 00, 792 H/c	
7	Width of Pellet Die	Drg. No.	660.12 H/c	Slot length 28.5
8	Grooves as per Drawing	Drg. No.	324 H/c	Under cut 8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 H/c 21.5 x 8 x 8 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No. of Holes 12 Both Side
13	Tapping Hole Diameter		72.5 H/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 31.3 H/c	Tapping Depth 28.5
17	Visual Inspection Before Gun Drilling		Yes OK	

Inspected By (Sign) & Date

Ravi 28/8/24

1	As per programme no.			2 Slot
2	Gun Drilling Work Completed On			32.1 H/c width
3	Hole Finish In Gun Drilling	Marked	OK	8 H/c Deep
4	Defective Holes (If Any)		No	Both Side

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter, 60
2	External Relief Dia	4.5 H/c	20 Side (3-3)		Inner			Low, 47
3	External Relief Depth		28 H/c		15 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			7	8	24		

Inspected By (Sign) & Date

Ravi 28/8/24

7/8/24

Reviewed by (Engineer-CNC)

Manager-QA