



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.		12924	98140
2	Machined By		V.T.L H/c Shop	Drg. No. 12.0.2.01
3	Pallet Die No.		12459(2.5)H/C	Rev. 01
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	500H/C Step 00 = 499H/C	Tappet = 12"
6	Inside Diameter	Dr. No.	4120.12 H/C	Step length = 17mm
7	Width of Pellet Die	Dr. No.	158.1H/C	
8	Grooves as per Drawing	Dr. No.	12x8x3H/C 12x8x3H/C	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes = 8 Both Side
12	Tapping PCD		454H/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 = 18.3H/C	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/9/24

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
2	External Relief Dia	9.8 H/C	Outside (3.3)	Inner			low = 28
3	External Relief Depth		18 H/C	12 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		20	9	24		

Inspected By (Sign) & Date

Ravi 20/9/24

Reviewed by (Engineer-CNC)

Manager-QA