



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.		12527	13150
2	Machined By		V. T. L. H/c Shop	Drg No. 1.20 998
3	Pallet Die No.		13102 (4.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Perforator	
5	Out Side Diameter	Drg. No.	320 H/c	Step OD, Tappers 12°
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8+5 H/c	13x8+5 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 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/07/24

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	4.5 H/c	outside 23-37		inner		Ravi 31
3	External Relief Depth		11 H/c		7 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		3	10	24		

Inspected By (Sign) & Date

Ravi 31/07/24

Reviewed by (Engineer-CNC)

Manager-QA