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.		12978	40/47
2	Machined By		V.T.L N/C Shop	Drg No. 1.2.C.15431 Rev 2
3	Pallet Die No.		13111 (3.0) HH	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	614 HH, Step OD: 612 HH	Step length 9.5
6	Inside Diameter	Drg. No.	520.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13x8x5 HH / 13x8x5 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		565 HH	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 HH Tapping Depth: 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 7/10/24	
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 — 1 Hole Closed	

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

1	Counter Sinking Depth & Finish	ok							Counter 60° Depth 3.8
2	External Relief Dia	3.5 HH	Outside (3-3)			Inner			
3	External Relief Depth		13 HH			7 HH			
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	10	24				
	Inspected By (Sign) & Date		Ravi 7/10/24						

Reviewed By (Engineer-CNC) 7/10/24

Manager-QA

Scanned with CamScanner