



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.		13163	45/50
2	Machined By		V. T. H. H/c Shop	Dy. No. 6, 2, 1, 3, 10
3	Pallet Die No.		13439 (5.0) H/c	Res. 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.00 H/c Step 00. 491 H/c	Step length 21.4
6	Inside Diameter	Drg. No.	4.20 ± 0.12 H/c	
7	Width of Pellet Die	Drg. No.	15.8 H/c	
8	Grooves as per Drawing	Drg. No.	12 × 8 × 3 H/c 12 × 8 × 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		45.4 H/c	Tapping H/c of holes B Both Side
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 H/c Tapping Depth = 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/10/24

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

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

Counters 60°

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	5.5 H/c	Outside (2-2)	Inner				
3	External Relief Depth		10 H/c	5 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		30	10	24			

Inspected By (Sign) & Date

Ravi 30/10/24

Satish 30/10/24

Reviewed by (Engineer-CNC)

Manager-QA