



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13340	40/48/55
2	Machined By		V. T. L. H/c Shop	Drg. No. 13.0.266
3	Pallet Die No.		13405(B.O)H/H	Rev. 100
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710H/H, Step 00, 693H/H	Tapper. 12°
6	Inside Diameter	Drg. No.	600.12 H/H	Step length 60H/H
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/H / 12x10x7.5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		640 H/H	Tapping No. of holes 12 Both Side
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/H	Tapping Depth, 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/11/24

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

Counter 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.5 H/H	6.5 H/H	6.5 H/H All Rows 2	15 H/H					
3	External Relief Depth			7.0 H/H All Rows 7	7 H/H					
4	Inspection Done Before Hardening By (Name)			Ravi						
5	Material Sent For Hardening By (Name)			Lark Pornece						
6	Material Sent For Hardening On Date			25	11	24				

Inspected By (Sign) & Date

Ravi 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA