



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.			
2	Machined By		13157	60/66
3	Pallet Die No.		V.T.L H/c Shop	Drill Nos 1.80 9136
4	Die Category	Drg. No.	13940 (Q.5) H/c	Rev 01
5	Out Side Diameter	Drg. No.	S. Jumbo	
6	Inside Diameter	Drg. No.	1032 H/c Step OD = 1033 H/c	Tappet = 3°
7	Width of Pellet Die	Drg. No.	900.12 H/c	Step length = 32 H/c
8	Grooves as per Drawing	Drg. No.	375 H/c	Under cut = 0.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 8 x 13 H/c / 29.5 x 8 x 13 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No of Holes = 15 Both Side
13	Tapping Hole Diameter		970 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H24 = Check by H24 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 38.3 H/c	Tapping Depth = 38.4
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 10/12/24

1	As per programme no.			2 Slot 39.1 H/c width 7.5 H/c Deep Both Side
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
Low = 59

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.0 H/c	80 Side (4-4)	Inner				
3	External Relief Depth		13 H/c	6 H/c				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Burner				
6	Material Sent For Hardening On Date		10	12	24			

Inspected By (Sign) & Date

Ravi 10/12/24

Satish 10/11/24

Reviewed by (Engineer-CNC)

Manager-QA