



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.		13534 ✓	35/50 ✓
2	Machined By		V.T.L. H/c Shop	Dr. No. 1-2-29980
3	Pallet Die No.		13475(30) H/c ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Centraulide	
5	Out Side Diameter	Drg. No.	620 H/c, Step OD, Tapper = 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.	13484 5 H/c / 13484 5 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		565 H/c	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		M2 = Check by M2e Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 2.4 H/c Tapping Depth = 18.5 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 12/12/24

1	As per programme no.		—
2	Gun Drilling Work Completed On		—
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		N. - 1 Hole Closed (A)

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	3.5 H/c	Outside (3-3)		Inner		Rais = 38
3	External Relief Depth		21 H/c		15 H/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Forge
6	Material Sent For Hardening On Date		12	12	24		

Inspected By (Sign) & Date

Ravi 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA