



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.		13542	40/50
2	Machined By		V.T.L. H/c	Step
3	Pallet Die No.		13156 (4.0) H/c	Recess
4	Die Category	Drg. No.	Jumbo 90	
5	Out Side Diameter	Drg. No.	730 H/c	Step OD = 748.4 H/c
6	Inside Diameter	Drg. No.	630.12 H/c	Step length = 83 H/c
7	Width of Pellet Die	Drg. No.	290 H/c	Undercut = 6.75
8	Grooves as per Drawing	Drg. No.	1548 x 5 H/c / 1528 x 5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Step	Tapping Ho of Holes = 16 Both Side
12	Tapping PCD		685 H/c	
13	Tapping Hole Diameter		M2 = Check by new Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 2.4 H/c	Tapping Depth = 18.6
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)		No - 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	4.5 H/c	outside (2.3)		inner			Row = 43
3	External Relief Depth		14 H/c		10 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		12	12	24			

Inspected By (Sign) & Date

Ravi 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA