



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.		13416 ✓	30/5/166
2	Machined By		V.T.L. H/C Shop	Drg. No. 1.80-609
3	Pallet Die No.		13793 (6.0) H/C	Rev = 03
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/C	Step 0.2, 6.3 H/C, Tapper 3°
6	Inside Diameter	Drg. No.	546.1 H/C	Step length = 0.1 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut = 2.5 H/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/C	(4 x 8) 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		619 H/C	
13	Tapping Hole Diameter		H16 = Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 H/C	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/12/24

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	

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

1	Counter Sinking Depth & Finish	ok						Counter = 30°
2	External Relief Dia	6.5 H/C 7.0 H/C	6.5 H/C	All Rows = 30 H/C				Row = 12
3	External Relief Depth		7.0 H/C	All Rows = 15 H/C				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Roxace
6	Material Sent For Hardening On Date		"	12	24			

Inspected By (Sign) & Date Ravi 11/12/24

Reviewed by (Engineer-CNC) Satish 12/12/24

Manager-QA