



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.		13725	36/42
2	Machined By		V.T.L. n/c Shop	Drg. No. 1.3.0-968
3	Pallet Die No.		13689 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	60.4 n/c, Step 00. 68.15 n/c	Tapper = 12
6	Inside Diameter	Drg. No.	52.12 n/c	Step length = 21.5 n/c
7	Width of Pellet Die	Drg. No.	22.2 n/c	Under cut = 8.75
8	Grooves as per Drawing	Drg. No.	1378x5 n/c / 1378x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		56.5 n/c	
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 = 20.2 n/c	Tapping Depth = 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 31/12/24	
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		Center = 60° Ramp = 38
2	External Relief Dia	3.3 n/c	All Rows	
3	External Relief Depth		6 n/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		31 12 24	
Inspected By (Sign) & Date			Ravi 31/12/24	

Reviewed by (Engineer-CNC)
Sats 31/12/24

Manager-QA