



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.		13795	36/42
2	Machined By		V.T.L. H/c Shop	Dy. No. 130-988
3	Pallet Die No.		13690 (B.O) H/c	Rev. No.
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	604 H/c Step OD: 621.5 H/c	Tapper: 12°
6	Inside Diameter	Drg. No.	520.12 H/c	Step length: 21.5
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut: 8.75
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 202 H/c Tapping Depth = 18.6 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi Bhatnagar

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

Counter - 60

1	Counter Sinking Depth & Finish	OK								Rev: 38
2	External Relief Dia	B.3 H/c	All Rows							
3	External Relief Depth		B 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		31	12	24					

Inspected By (Sign) & Date

Ravi 31/12/24

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

Manager-QA