



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)

9032

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13991	32/50
2	Machined By		V. T. L. H/c Shop	Dy. No. L.S.C. 9980
3	Pallet Die No.		13827 (3.5) H/c	Rev 2 00
4	Die Category	Drg. No.	6-side	
5	Out Side Diameter	Drg. No.	620 H/c, Step OD = Tapped 12°	
6	Inside Diameter	Drg. No.	520.12 H/c 520.14 H/c	Step length 13.5
7	Width of Pellet Die	Drg. No.	222 H/c	
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 Back side
12	Tapping PCD		565 H/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 H/c Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/1/25

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

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

1	Counter Sinking Depth & Finish	ok						Counter 6
2	External Relief Dia	40 H/c	outside (3-3)		inner			Rev = 35
3	External Relief Depth		21 H/c		18 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		21	1	25			

Inspected By (Sign) & Date

Ravi 21/1/25

Satyam 21/1/25
Reviewed by (Engineer-CNC)

Manager-QA