



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

6016

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10152	410/50
2	Machined By		V.T.L H/c Shop	Drg No. (S.S. 92) 493
3	Pallet Die No.		9695 (8.0) H4	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H4, Step OD: 693 H4	Step length 30 H4
6	Inside Diameter	Drg. No.	800.12 H4	Tappet 12°
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H4 / 12x10x7.5 H4	
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		640 H4	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 H4	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/8/23

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								Ravi 18
2	External Relief Dia	8.5 H4	Outside (3-3)		Inner					
3	External Relief Depth		18 H4		10 H4					
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	8	23					

Inspected By (Sign) & Date

Ravi 31/8/23

Reviewed by (Engineer-CNC)

Manager-QA