



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6442

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.			
2	Machined By		10546	33/48/70
3	Pallet Die No.		V.T.L. H/C Shop	Drill 1.50, 377
4	Die Category	Drg. No.	10786 (G.O) H/H	Rev 203
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	688 H/H Step GD = 697.7 H/H	Tapper 2.5
7	Width of Pellet Die	Drg. No.	548.12 H/H	Step length 38.5
8	Grooves as per Drawing	Drg. No.	215 H/H	Under cut 1.8 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 10 x 8 H/H / 29.5 x 10 x 8 H/H	(6 x 8) H/H
10	Drilling Area Surface Smoothness		ok	Face side step H/H
11	Tapping Operator		ok	Deep Both side
12	Tapping PCD		N/C Shop	Tapping No
13	Tapping Hole Diameter		618 H/H	of Holes, 2
14	Tapping On Second Side	Half pitch of 1st side	NIG = Check by NIG Bolt	Both side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth, 32.4 H/H	Tapping Depth, 30.5
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 17/11/23

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					Counter 2.0
2	External Relief Dia	6.5 H/H 1.3 H/H	6.5 H/H All Lines	1.3 H/H All Lines			Rep = 14
3	External Relief Depth		37 H/H	22 H/H			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Forance
6	Material Sent For Hardening On Date		17	11	23		

Inspected By (Sign) & Date

Ravi 17/11/23

Reviewed by (Engineer-CNC)
Sahy 17/11/23

Manager-QA