



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.		10842	35/55/78
2	Machined By		Y.T.L. n/c Shop	Drg No. 18.0-390
3	Pallet Die No.		10903 (6.0) H	Rev 201
4	Die Category	Drg. No.	H-Tombs	
5	Out Side Diameter	Drg. No.	635 H / 632 H Step 002	630.5 H / 543 H
6	Inside Diameter	Drg. No.	480.1 H / 489.1 H / 500.1 H	Step length 26 H
7	Width of Pellet Die	Drg. No.	182 H	16.5 H
8	Grooves as per Drawing	Drg. No.	37x12x8x9.4 H / 27x12x8x9.4 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes = 4
12	Tapping PCD		540 H	
13	Tapping Hole Diameter		MIG Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 1st side One Slot	
15	Tapping Hole Depth		Drill Depth = 28.5 H Tapping Depth = 26.7 H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/12/23

1	As per programme no.			1 slot
2	Gun Drilling Work Completed On			28.1 H width
3	Hole Finish In Gun Drilling	Marked	ok	17 H Depth
4	Defective Holes (If Any)		No	

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

Counter = 30°

1	Counter Sinking Depth & Finish	ok						Ravi 10
2	External Relief Dia	1.0 H / 1.5 H	1.0 H All Lines	1.5 H All Lines				
3	External Relief Depth		43 H	23 H				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		13	12	23			

Inspected By (Sign) & Date

Ravi 13/12/23

Reviewed by (Engineer-CNC)

Manager-QA