



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9395 to 9840	40/85
2	Machined By		V.T.L. H.C. Shop	35/45/66
3	Pallet Die No.		10258 (8.0) H.C.	Dry No. 12.0 609
4	Die Category	Drg. No.	H.C. Jumbo	Reo 201
5	Out Side Diameter	Drg. No.	680.69 H.C. Step 00 = 693 H.C.	Tappera 8°
6	Inside Diameter	Drg. No.	548.12 H.C.	Step length = 31 H.C.
7	Width of Pellet Die	Drg. No.	195 H.C.	Under Cut = 2.5 H.C.
8	Grooves as per Drawing	Drg. No.	32.7 x 8 H.C. 32.7 x 8 H.C.	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Fore Side steps Back Both side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H.C. Shop	
12	Tapping PCD		619 H.C.	[Tapping Hole Hole = 4 H.C.]
13	Tapping Hole Diameter		H16 Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	Side
15	Tapping Hole Depth		Drill Depth = 33.3 H.C.	Tapping Depth = 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/23

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 30°
2	External Relief Dia	8.5 H.C. / 9.0 H.C.	1st Rad 26 H.C.	2nd Rad 21 H.C.	9.0 H.C.		Low 21°
3	External Relief Depth	9.0 H.C.	8.5 H.C.	8.1 H.C.	21 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		3	7	23		

Inspected By (Sign) & Date

Ravi 31/7/23

Reviewed by (Engineer-CNC)

Manager-QA