



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.		10804	30/38/50
2	Machined By		V.T.L. H/c Shop	Dy No 18.02-797
3	Pallet Die No.		11380 (4.0) H/c	Reo 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c, Step 00 = 792 H/c	Step length 06.5
6	Inside Diameter	Drg. No.	660.12 H/c	Undercut 6 H/c
7	Width of Pellet Die	Drg. No.	323.8 H/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H/c / 21.5 x 8 x 8 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 Both Side
12	Tapping PCD		725 H/c	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31mm, Tapping Depth 29.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 19/12/23	
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		Counters 2 30°
2	External Relief Dia	4.5 H/c / 5.0 H/c	4.5 H/c All Lines / 5.0 H/c All Lines	Row 2 47
3	External Relief Depth		3.0 H/c / 2.2 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		19 12 23	
Inspected By (Sign) & Date			Ravi 19/12/23	

Reviewed by (Engineer-CNC)

Manager-QA