



Lark Engineering Company (India) Pvt. Ltd.

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

6717

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		10940	34/45
3	Pallet Die No.		V.T.I. h/c Shop	Dy No. 1.2.011553
4	Die Category	Drg. No.	10519 (3.0) H4	Revised
5	Out Side Diameter	Drg. No.	38870	
6	Inside Diameter	Drg. No.	610 H4, Step 00, 624 H4	Tapper 12
7	Width of Pellet Die	Drg. No.	520.12 H4	Step length 18 H4
8	Grooves as per Drawing	Drg. No.	186 H4	Under cut 7 H4
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H4 / 13x8x3 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	Tapping No of holes 12 Both side
13	Tapping Hole Diameter		565 H4	
14	Tapping On Second Side	Half pitch of 1st side	H222 Check by H22 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 21. H4 Tapping Depth 19 H4	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 29/12/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		nil

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

1	Counter Sinking Depth & Finish	ok					Counter 60°
2	External Relief Dia	3.5 H4	outside (2-3)	inner			
3	External Relief Depth		24 H4	21 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		29	12	25		

Inspected By (Sign) & Date

Ravi 29/12/23

29/12/23

Reviewed by (Engineer-CNC)

Manager-QA