



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

6727

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10997	27/47
3	Pallet Die No.		V.T.C. n/c Step	Drg. No. 6.30.91397
4	Die Category	Drg. No.	11866 (3.0) n/c	Reo. m
5	Out Side Diameter	Drg. No.	Endside	
6	Inside Diameter	Drg. No.	614 n/c, Step OD = 621.5 n/c	Tap hole = 12°
7	Width of Pellet Die	Drg. No.	520.6 n/c / 520.12 n/c	Step length = 21.5
8	Grooves as per Drawing	Drg. No.	222 n/c	Undercut = 3.75
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Step	Tapping Hole of H-to = 12° Both Side
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 = Check by M20 Bolt	
15	Tapping Hole Depth		ok	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		Drill Depth = 20.7 n/c	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 5/1/24

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 = 60°
2	External Relief Dia	3.5 n/c	outside (2-3)	Inner			Ravi 31
3	External Relief Depth	"	23 n/c	20 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Portage				
3	Material Sent For Hardening On Date		5	1	24		

Inspected By (Sign) & Date

Ravi 5/1/24