



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.			
2	Machined By		11033	40/50
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 1.S.O. 281
4	Die Category	Drg. No.	11552 (4.0)H	Rev 2.00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	52.44, Step OD = 49.94	Tapper = 10°
7	Width of Pellet Die	Drg. No.	42.12 H	Step length = 19.4
8	Grooves as per Drawing	Drg. No.	158 H	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H 12x2x3 H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No of Holes = 8 Both Side
13	Tapping Hole Diameter		454 H	
14	Tapping On Second Side	Half pitch of 1st side	0.314" Check by 0.314" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 21.8 H, Tapping Depth = 19.2	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 6/1/24

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° Rows = 20
2	External Relief Dia	4.5 H	Outside (2-2)	Inner			
3	External Relief Depth		14 H	10 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		6	1	24		

Inspected By (Sign) & Date

Ravi 6/1/24

Reviewed by (Engineer-CNC)

Manager-QA