



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		11061/	33/50/
3	Pallet Die No.		N.T.L. H/C Shop	Dry Holes L.F.C. 11886
4	Die Category	Drg. No.	11390 (H.C.) H/H	Res = 0.2/
5	Out Side Diameter	Drg. No.	58810	
6	Inside Diameter	Drg. No.	620 H/H / Step OD = 623.5 H/H	Tapper = 12°
7	Width of Pellet Die	Drg. No.	520.12 H/H	Step length = 12 H/H
8	Grooves as per Drawing	Drg. No.	186 H/H	Under cut = 1.8 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H/H / 13x8x3 H/H	
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 H/H	
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 21.2 H/H Tapping Depth = 18.8 H/H	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 9/1/24

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 = Go
2	External Relief Dia	4.5 H/H	Outside (3-3)	Inner			Reverse side
3	External Relief Depth		21 H/H	17 H/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		9	1	24		

Inspected By (Sign) & Date

Ravi 9/1/24

Reviewed by (Engineer-CNC)

Manager-QA