



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11048	30/44/50
2	Machined By		V. T. L. H/C Shop	Drg No. 1.20.148.05
3	Pallet Die No.		8891 (3.0) H/C	Rev. 2.02
4	Die Category	Drg. No.	MJER	
5	Out Side Diameter	Drg. No.	701 H/C Step 00 - Tapper 12°	Step length 17.1
6	Inside Diameter	Drg. No.	600.14 H/C	
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/C / 15x8x7 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 - 16 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.1 H/C Tapping Depth 18.8 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/1/24

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

Counters 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 H/C / 4.0 H/C	3.5 H/C All Lines	4.0 H/C All Lines					
3	External Relief Depth		14 H/C	6 H/C					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Porname						
6	Material Sent For Hardening On Date		10	1	24				

Inspected By (Sign) & Date

Ravi 10/1/24

Reviewed by (Engineer-CNC)

Manager-QA