



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.		11089/	31/40
2	Machined By		V. T. L. N/C Shop	Dry No. 2 L.E. 0215062
3	Pallet Die No.		10958 (2.8) H/H	Rev = 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/H / Step 00 = 498.38	Tapper = 12°
6	Inside Diameter	Drg. No.	420.14 H/H (D)	Step length = 13
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H / 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of leads = 8 Rota Side
12	Tapping PCD		454 H/H / 453.9 H/H	
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 = 19.8 H/H	Tapping Depth = 17.2 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/1/24

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

Counter = 60°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.1 H/H	Outside (2-2)		Inner				
3	External Relief Depth		15 H/H		9 H/H				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		13	1	24				

Inspected By (Sign) & Date

Ravi 13/1/24

[Signature]
13/1/24

Reviewed by (Engineer-CNC)

Manager-QA