



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)

6284

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11087	29/42
2	Machined By		V.T.L. n/c Shop	Dry die last 3195 3310
3	Pallet Die No.		10946 (3.0) H4	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4 Step OD = 491 H4	Step length 7.4
6	Inside Diameter	Drg. No.	420.12 H4	
7	Width of Pellet Die	Drg. No.	158 H4	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H4 / 12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/c Shop	Tapping No. of 4.4 or 8 Bolt side
12	Tapping PCD		454 H4	
13	Tapping Hole Diameter		N20 Check by N20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 19.8 H4	Tapping Depth 7.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/1/24

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 Sinking Depth & Finish	External Relief Dia	External Relief Depth	Inspection Done Before Hardening By (Name)	Material Sent For Hardening By (Name)	Material Sent For Hardening On Date
1	OK					
2	3.5 H4	outside (2-2)	14 H4	Ravi	Last Furnace	
3						
4						
5						
6						

Inspected By (Sign) & Date

Ravi 15/1/24

Reviewed by (Engineer-CNC)

Manager-QA