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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.		11050/	42/55
2	Machined By		V.T.L N/C Shop	Dyatar 1.2.0 = 420 So Rad = 00
3	Pallet Die No.		11633 (6.0) HH	
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 HH / Step OD. 692.1 HH Step length = 19.4	
6	Inside Diameter	Drg. No.	600.12 HH / 600.14 HH (A)	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 HH / 12.5 x 8 x 7 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes: 12 Both Side
12	Tapping PCD		645 HH/	
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: 93.1 HH Tapping Depth: 90.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 25/1/24	
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° Rad = 28

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	6.5 HH	OD Side (3-3)		Inner			
3	External Relief Depth		19 HH		13 HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forrace					
6	Material Sent For Hardening On Date		25	1	24			
	Inspected By (Sign) & Date		Ravi 25/1/24					

Reviewed by (Engineer-CNC) Satya 25/1/24

Manager-QA

Scanned with CamScanner