



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.		11118	40/50
2	Machined By		V.T.C H/c Shop	Drg No. 18012501
3	Pallet Die No.		11204 (B.2) H/c	Rev. 01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c, Step 002 692.3 H/c	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 20 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/c / 12x8x7 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 = 12 Both Side
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4 H/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/2/24

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 - 2 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60°
 Range = 33

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.3 H/c	Outside 83-3)		Inner		
3	External Relief Depth		14 H/c		10 H/c		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						Lark Forance
6	Material Sent For Hardening On Date		1	2	24		

Inspected By (Sign) & Date

Ravi 11/2/24

Reviewed by (Engineer-CNC)

Manager-QA