



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

6865

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11173	44/50
3	Pallet Die No.		V-7-L n/c Shop	Dry the lark 355
4	Die Category	Drg. No.	11604 (4.0) n/c	310
5	Out Side Diameter	Drg. No.	Extrude	
6	Inside Diameter	Drg. No.	620.1 n/c Step OD = 612.1 n/c	Step length 19.4
7	Width of Pellet Die	Drg. No.	520.12 n/c	
8	Grooves as per Drawing	Drg. No.	222.1 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes 12 Both Side
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 = Check by M20 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 21.3 n/c	Tapping Depth = 8.8
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Pasi 29/1/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		N.

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

1	Counter Sinking Depth & Finish	ok					Counter = 6°
2	External Relief Dia	4.3 n/c	outside (3-31)		Inner		Rap = 31
3	External Relief Depth		14 n/c		6 n/c		
4	Inspection Done Before Hardening By (Name)						Pasi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		29	1	24		

Inspected By (Sign) & Date

Pasi 29/1/24

Sasi 29/1/24

viewed by (Engineer-CNC)

Manager-QA