



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.		11149	33/50
2	Machined By		V.T.L. H/c Shop	Drg No. 1.3.D. 450
3	Pallet Die No.		11521 (3.0) H/c	Rev = 00
4	Die Category	Drg. No.	J820	
5	Out Side Diameter	Drg. No.	730 H/c, Step OD: 743.4 H/c	Step length: 33 H/c
6	Inside Diameter	Drg. No.	630.12 H/c	Tapper: 10°
7	Width of Pellet Die	Drg. No.	290 H/c	Under cut = 6.7 H/c
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c 15x8x5 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: 16 Both Side
12	Tapping PCD		685 H/c	
13	Tapping Hole Diameter		M2 = Check by M2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.8 H/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 30/1/24

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 = 63

1	Counter Sinking Depth & Finish	ok								Rev = 52
2	External Relief Dia	3.3 H/c	outside (3-3)		Inner					
3	External Relief Depth		2.3 H/c		1.7 H/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark furnace
6	Material Sent For Hardening On Date			30	1	24				

Inspected By (Sign) & Date Ravi 30/1/24

Reviewed by (Engineer-CNC)

Manager-QA