



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

6871

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11181	30/42
3	Pallet Die No.		V.T.L. H/c Shop	Qty Holes 13.01 968
4	Die Category	Drg. No.	11608 (3.0) H/H	Rev 2.00
5	Out Side Diameter	Drg. No.	Centre wide	
6	Inside Diameter	Drg. No.	604 H/H Step 00 = 621.5 H/H	Tapping 12"
7	Width of Pellet Die	Drg. No.	580.12 H/H	Step length 21.5 H/H
8	Grooves as per Drawing	Drg. No.	222 H/H	Under cut 28.7 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No. of Holes 12 Both Side
13	Tapping Hole Diameter		565 H/H	
14	Tapping On Second Side	Half pitch of 1st side	H22 Check by H22 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 21.4 H/H	Tapping Depth 19 H/H
17	Visual Inspection Before Gun Drilling		yes 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 = 60°

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.5 H/H	3.5	All Rows				
3	External Relief Depth			8 H/H				
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