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.		10824	75/75
2	Machined By		V.T.L. H/c. Shop	Dwg No. LSD-691 Rev-00
3	Pallet Die No.		11775 (8.0) HH	
4	Die Category	Drg. No.	5. Jumbo	
5	Out Side Diameter	Drg. No.	106 HH Step OD = 104 HH	Tapper 4° Step length 9 HH
6	Inside Diameter	Drg. No.	911.12 HH / 911.14 HH (A)	
7	Width of Pellet Die	Drg. No.	388 HH	
8	Grooves as per Drawing	Drg. No.	33x10x9.8 HH / 33x10x9.8 HH	Face Side Step 1 HH Back Side
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		97.5 HH	
13	Tapping Hole Diameter		M24 = Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth. 40.8 HH Tapping Depth. 38.4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 23/2/24	
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	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker — Counter 60°

1	Counter Sinking Depth & Finish	Ok						Ravi 30
2	External Relief Dia	9.0 HH	Outside (3-3)		Inner			
3	External Relief Depth		8 HH		Nill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		23	2	24			
	Inspected By (Sign) & Date		Ravi 23/2/24					

Sat 23/2/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner