



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.		11351	38/46/55
2	Machined By		N. T. L. H/C Shop	Dr. H. L. S. C. 14/9/24
3	Pallet Die No.		11357 (4.0) H/C	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630 H/C Step 002 612 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 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 Back Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 21 H/C Tapping Depth - 18	7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 26/2/24

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°				Ravi 31	
1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 H/C 5.0 H/C	4.5 H/C	All Rows	5.0 H/C	All Rows	
3	External Relief Depth		19 H/C		9 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		26	2	24		

Inspected By (Sign) & Date Ravi 26/2/24

Reviewed by (Engineer-CNC) Satyam 26/2/24

Manager-QA