



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

7018

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11165	33/38/66
2	Machined By		V.T.L H/C Shop	Qty 1.3.0-809
3	Pallet Die No.		11907 (6.0) H/C	Rev 2.01
4	Die Category	Drg. No.	H-Jumbo	
5	Out Side Diameter	Drg. No.	680-69 H/C Step 00, 693 H/C	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 H/C	Step length 31 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut 2.5 H/C
8	Grooves as per Drawing	Drg. No.	30.7.8 H/C 30.8.7.8 H/C (4.0) H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[Face Side Step 2 H/C Back Both Side]
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 H/C	Tapping No of holes 4
13	Tapping Hole Diameter		H16 2 Check by H16 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 H/C	Tapping Depth 31.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/7/24

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

1	Counter Sinking Depth & Finish	OK						Counter 30°
2	External Relief Dia	6.5 H/C 7.5 H/C	6.5 H/C All Rows	7.5 H/C All Rows				Rev 2.12
3	External Relief Depth		33 H/C	98 H/C				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Porrore					
6	Material Sent For Hardening On Date		27	2	24			

Inspected By (Sign) & Date

Ravi 27/7/24

Reviewed by (Engineer-CNC)

Manager-QA