



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.		11450/	24/45/
2	Machined By		V.T.C. H/c Shop	Drill No. 18.9.527
3	Pallet Die No.		11785 (B.O) H/c	Rev. No.
4	Die Category	Drg. No.	2x2x2 side	(A)
5	Out Side Diameter	Drg. No.	610 H/c, Step 00, 622.3 H/c	Tapper 12°
6	Inside Diameter	Drg. No.	580.12 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut 6.15
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 H/c of Holes 12 Both 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 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 5/3/24

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° Row 238

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.3 H/c	outside (3-3)	inner			
3	External Relief Depth		24 H/c	21 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		5	3	24		

Inspected By (Sign) & Date

Ravi 5/3/24

Saty 5/3/24

Reviewed by (Engineer-CNC)

Manager-QA