



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.		11384	
2	Machined By		V.T.L n/c Shop	
3	Pallet Die No.		11935(4.0)H	
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790H Step OD, 792H	Step length 98.5
6	Inside Diameter	Drg. No.	660.12 H / 660.14 H (B)	Under cut, 1H
7	Width of Pellet Die	Drg. No.	324 H	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H / 20.5 x 9 x 8 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 H	Tapping Hole of holes 12 Roh Side
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 31.6 H Tapping Depth 20.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 6/3/24	
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				
1	Counter Sinking Depth & Finish		OK	Counter 30
2	External Relief Dia	4.5 H / 5.0 H	4.5 H All Rows	5.0 H All Rows
3	External Relief Depth		35 H	27 H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		6	3
Inspected By (Sign) & Date			Ravi 6/3/24	

Reviewed by (Engineer-CNC)

Manager-QA