



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.		11452	41/51 49/50
2	Machined By		V. T. L H/c Shop	Dy. H/c LFC 10295
3	Pallet Die No.		11418 (3.0) H/H	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	68.2 H/H	Step 00, Tapped 12° Step length 38mm
6	Inside Diameter	Drg. No.	58.0 H/H	
7	Width of Pellet Die	Drg. No.	266 H/H	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 H/H	28.5 x 6 x 12 H/H
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		630 H/H	
13	Tapping Hole Diameter		H16 = Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25.8 H/H	Tapping Depth = 23.8 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/3/24

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

1	Counter Sinking Depth & Finish	ok							Low = 42
2	External Relief Dia	3.5 H/H	Outside (3-3)		Inner				
3	External Relief Depth		16 H/H		10 H/H				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		13	3	24				

Inspected By (Sign) & Date

Ravi 13/3/24

Reviewed by (Engineer-CNC)
13/3/24

Manager-QA