



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

7/21

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11434	29/47
3	Pallet Die No.		V.T.L H/c Shop	Dy. No. L-80-15431
4	Die Category	Drg. No.	11960 (2.8) H/c	Row 20
5	Out Side Diameter	Drg. No.	Ends wide	
6	Inside Diameter	Drg. No.	614 H/c Step OD 618 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	52012 H/c	
8	Grooves as per Drawing	Drg. No.	322 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of Holes - 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 H/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/3/24

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						Coorder = 60
2	External Relief Dia	3.1 H/c	outside (3.3)	inner				Row 2 40
3	External Relief Depth		20 H/c	18 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		18	3	24			

Inspected By (Sign) & Date

Ravi 18/3/24

Signature
18/3/24

Reviewed by (Engineer-CNC)

Manager-QA