



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11608	35/42
2	Machined By		V.T.L n/c Shop	Dy. Hrs 1.8.24/10/14
3	Pallet Die No.		11404 (3.5) H	Rev 2.00
4	Die Category	Drg. No.	55570	
5	Out Side Diameter	Drg. No.	60.4 H, Step OD = 61.2 H	Step length 19.6
6	Inside Diameter	Drg. No.	52.12 H	Under cut 2.4 H
7	Width of Pellet Die	Drg. No.	186 H	
8	Grooves as per Drawing	Drg. No.	13x8x3 H 13x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of holes 12 Both Side
12	Tapping PCD		56.5 H	
13	Tapping Hole Diameter		M20 - Check by M20 Bore	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.7 H	Tapping Depth = 18.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/4/24	
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 sink 60°
2	External Relief Dia		3.8 H	All Rows
3	External Relief Depth		7 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		4 4 24	
Inspected By (Sign) & Date			Ravi 4/4/24	

Reviewed by (Engineer-CNC)

Manager-QA