



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.		11590	98/40
2	Machined By		V.T.L H/C Shop	Dy No. 18.02.01
3	Pallet Die No.		11298 (2.5) H/H	Rev 2.0
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/H Step OD = 499 H/H	Tapper 12°
6	Inside Diameter	Drg. No.	490.12 H/H	Step length 12 H/H
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H / 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		03/4" - Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.8 H/H	Tapping Depth 18.8
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 - 2 hole Colused (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 60°
2	External Relief Dia	2.8 H/H	outside (2-2)	Inner				
3	External Relief Depth		18 H/H	12 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		4	4	24			

Inspected By (Sign) & Date

Ravi 4/4/24

Reviewed by (Engineer-CNC)

Manager-QA