



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7304

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.			
2	Machined By		11689	15/45
3	Pallet Die No.		V.T.C. H/C Shop	Drg No. 13.0.1080
4	Die Category	Drg. No.	11437 (3.0) H/C	Rev. 2.00
5	Out Side Diameter	Drg. No.	N. Jumbo	
6	Inside Diameter	Drg. No.	7.80 H/C, Step 00, 7.43 H/C	Step length = 7.5
7	Width of Pellet Die	Drg. No.	630.12 H/C	Tapper 4°
8	Grooves as per Drawing	Drg. No.	255	Identical 11.5 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	22x28x7 H/C / 22x28x7 H/C	
10	Drilling Area Surface Smoothness	Drg. No.	ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		685 H/C	
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 29 H/C Tapping Depth 26.9 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 12/4/24

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 2 60° Raws = 48
2	External Relief Dia	3.5 H/C	Outside (3-3)	Inner				
3	External Relief Depth		4 H/C	Mill				
4	Inspection Done Before Hardening By (Name)		Sasi					
5	Material Sent For Hardening By (Name)		Lark Formace					
6	Material Sent For Hardening On Date		12	4	24			
Inspected By (Sign) & Date		Sasi 12/4/24						

Reviewed by (Engineer-CNC)
Sasi 12/4/24

Manager-QA