



Lark Engineering Company (India) Pvt. Ltd.

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

7305

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.		11691	
2	Machined By		V.T.C. H/c Shop	26/40
3	Pallet Die No.		11318 (3-0) H/c	9.95 Dy 11-2 (ext 3379)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158.1 H/c	
8	Grooves as per Drawing	Drg. No.	120.8 = 3 H/c 120.8 = 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		M20 = Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.8 H/c	Tapping Depth = 17.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/4/24

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

Coorder = 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.5 H/c	Outside (2-2)		Inner					
3	External Relief Depth		17 H/c		14 H/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Royce
6	Material Sent For Hardening On Date			12	4	24				

Inspected By (Sign) & Date

Ravi 18/4/24

Satish 12/4/24

Reviewed by (Engineer-CNC)

Manager-QA